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(54) Title: SYNTHETIC POROUS CRYSTALLINE MATERIAL ITS SYNTHESIS AND USE (57) Abstract <p>This invention relates to a composition of matter comprising an inorganic, porous crystalline phase material exhibiting, after calcination, an X-ray diffraction pattern with at least one peak at a d-spacing greater than 1.8 nm and having a benzene adsorption capacity of greater than 15 grams benzene per 100 grams of said material at 6.7 kPa (50 torr) and 25 °C. Preferably, the crystalline phase material has a hexagonal arrangement of uniformly-sized pores at least 1.3 nm in diameter and exhibiting, after calcination, a hexagonal electron diffraction pattern that can be indexed with a d_{100} value greater than 1.8 nm.</p>		

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SYNTHETIC POROUS CRYSTALLINE MATERIAL
ITS SYNTHESIS AND USE

This invention relates to a synthetic porous crystalline material, its synthesis and its use as a sorbent or a catalyst component.

Porous inorganic solids have found great utility as catalysts and separation media for industrial application. The openness of their microstructure allows molecules access to the relatively large surface areas of these materials that enhance their catalytic and sorptive activity. The porous materials in use today can be sorted into three broad categories using the details of their microstructure as a basis for classification. These categories are the amorphous and paracrystalline materials, the crystalline molecular sieves and modified layered materials. The detailed differences in the microstructures of these materials manifest themselves as important differences in the catalytic and sorptive behavior of the materials, as well as in differences in various observable properties used to characterize them, such as their surface area, the sizes of their pores and the variability in those sizes, the presence or absence of X-ray diffraction patterns and the details in such patterns, and the appearance of the materials when their microstructure is studied by transmission electron microscopy and electron diffraction.

Amorphous and paracrystalline materials represent an important class of porous inorganic solids that have been used for many years in industrial applications. Typical examples of these materials are the amorphous silicas commonly used in catalyst formulations and the paracrystalline transitional aluminas used as solid

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acid catalysts and petroleum reforming catalyst supports.

5 The term "amorphous" is used herein to indicate a material with no long range order so that the pores of the material tend to be distributed over a wide range of sizes. An alternate term that has been used to describe these materials is "X-ray indifferent", since the lack of order also manifests itself in the X-ray diffraction pattern, which is usually featureless. The porosity of amorphous materials, such as the amorphous silicas, generally results from voids between the individual particles.

10 Paracrystalline materials such as the transitional aluminas also have a wide distribution of pore size, but better defined X-ray diffraction patterns usually consisting of a few broad peaks. The microstructure of these materials consists of tiny crystalline regions of condensed alumina phases and the porosity of the materials results from irregular voids between these regions (K. Wefers and Chanakya Misra, "Oxides and Hydroxides of Aluminum", Technical Paper No. 19 Revised, Alcoa Research Laboratories, p. 54-59, 1987).

15 The size of the pores in amorphous and paracrystalline materials fall into a regime called the mesoporous range which, for the purposes of this application, is from 1.3 to 20 nm.

20 In sharp contrast to these structurally ill-defined solids are materials whose pore size distribution is very narrow because it is controlled by the precisely repeating crystalline units of the three-dimensional framework of the material. These materials are called "molecular sieves", the most important examples of which are zeolites. The precise crystalline microstructure of most zeolites manifests itself in a well-defined X-ray diffraction pattern that usually contains many sharp maxima and that serves to uniquely define the material. Similarly, the

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dimensions of pores in these materials are very regular, due to the precise repetition of the crystalline microstructure. All molecular sieves discovered to date have pore sizes in the microporous range, which is usually quoted as 0.2 to 2 nm, with the largest reported being about 1.2 nm.

In layered materials, the interatomic bonding in two directions of the crystalline lattice is substantially different from that in the third direction, resulting in a structure that contains cohesive units resembling sheets. Usually, the bonding between the atoms within these sheets is highly covalent, while adjacent layers are held together by ionic forces or van der Waals interactions. These latter forces can frequently be neutralised by relatively modest chemical means, while the bonding between atoms within the layers remains intact and unaffected.

Thus in certain layered materials, adjacent layers may be urged apart with a swelling agent and then fixed in this separated position by the insertion of pillars to provide a material having a large degree of porosity. For example, certain clays may be swollen with water, whereby the layers of the clay are spaced apart by water molecules. Other layered materials are not swellable with water, but may be swollen with certain organic swelling agents such as amines and quaternary ammonium compounds. Examples of such non-water swellable layered materials are described in U.S. Patent 4,859,648 and include layered silicates, magadiite, kenyaite, trititanates and perovskites. Another example of a non-water swellable layered material, which can be swollen with certain organic swelling agents, is a vacancy-containing titanometallate material, as described in U.S. Patent 4,831,006.

The X-ray diffraction patterns of pillared layered materials can vary considerably, depending on the

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degree that swelling and pillaring disrupt the otherwise usually well-ordered layered microstructure. The regularity of the microstructure in some pillared layered materials is so badly disrupted that only one
5 peak in the low angle region on the X-ray diffraction pattern is observed, at a d-spacing corresponding to the interlayer repeat in the pillared material. Less disrupted materials may show several peaks in this region that are generally orders of this fundamental
10 repeat. X-ray reflections from the crystalline structure of the layers are also sometimes observed. The pore size distribution in these pillared layered materials is narrower than those in amorphous and paracrystalline materials but broader than that in
15 crystalline framework materials.

Layered materials frequently adopt sheetlike morphology mirroring the disparity in bonding that exists on the atomic level. Such morphological properties can be revealed by transmission electron
20 microscopy.

The invention present resides in a composition of matter comprising an inorganic, porous, non-layered crystalline phase material exhibiting, after
calcination, an X-ray diffraction pattern with at least
25 one peak at a d-spacing greater than 1.8 nm and having a benzene adsorption capacity of greater than 15 grams benzene per 100 grams of said material at 6.7 kPa (50 torr) and 25°C.

In a preferred embodiment, the invention resides
30 in a composition of matter comprising an inorganic, porous crystalline phase material having a hexagonal arrangement of uniformly-sized pores at least 1.3 nm in diameter and exhibiting, after calcination, a hexagonal electron diffraction pattern that can be indexed with a
35 d_{100} value greater than 1.8 nm.

The pore sizes referred to herein are not strict crystallographic dimensions but instead are effective pore sizes determined by sorption measurement. The

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preferred method of determining pore size employs argon physisorption, which is a known technique and is described in detail in Examples 21 (a) and 21 (b). In this method the mass of argon adsorbed by a sample at constant temperature but varying relative pressure above the sample is measured and used to plot an adsorption isotherm. The point on the isotherm corresponding to a rapid change of gradient indicates pore filling and can be used to determine pore size by the known mathematical relationships described in Example 21.

The crystalline (i.e. meant here as having sufficient order to provide, after calcination, a diffraction pattern with at least one peak by, for example, X-ray, electron or neutron diffraction) material of this invention may be characterized by its heretofore unknown structure, including extremely large pore windows, and high sorption capacity. In general, the material of the invention is "mesoporous", by which is meant that the material has uniform pores of diameter within the range of 1.3 to 20 nm. More preferably, the materials of the invention have uniform pores of diameter within the range 1.8 to 10 nm. In this respect, pore size is considered as the maximum perpendicular cross-sectional dimension of the pore.

The material of the present invention can be distinguished from other porous inorganic solids by the regularity of its large open pores, whose size more nearly resembles that of amorphous or paracrystalline materials, but whose regular arrangement and uniformity of size (pore size distribution within a single phase of, for example, $\pm 25\%$, usually $\pm 15\%$ or less of the average pore size of that phase) more closely resemble those of crystalline framework materials such as zeolites.

In the preferred arrangement, the porosity of the crystalline material of the invention is provided by a

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generally hexagonal arrangement of open channels, a property that can be readily observed by electron diffraction and transmission electron microscopy. In particular, the transmission electron micrograph of properly oriented specimens of the material show a hexagonal arrangement of large channels and the corresponding electron diffraction pattern gives an approximately hexagonal arrangement of diffraction maxima. The d_{100} spacing of the electron diffraction patterns is the distance between adjacent spots on the $hk0$ projection of the hexagonal lattice and is related to the repeat distance a_0 between channels observed in the electron micrographs through the formula $d_{100} = a_0 \sqrt{3}/2$. This d_{100} spacing observed in the electron diffraction patterns corresponds to the d -spacing of a low angle peak in the X-ray diffraction pattern of the material. The most highly ordered preparations of the material obtained so far have 20-40 distinct spots observable in the electron diffraction patterns. These patterns can be indexed with the hexagonal $hk0$ subset of unique reflections of 100, 110, 200, 210, etc., and their symmetry-related reflections.

In this respect, it is to be understood that the reference to a hexagonal arrangement of channels is intended to encompass not only mathematically perfect hexagonal symmetry but also an arrangement in which most channels in the material are surrounded by six nearest neighbor channels at substantially the same distance. Defects and imperfections will cause significant numbers of channels to violate this criterion to varying degrees. Samples which exhibit as much as $\pm 25\%$ random deviation from the average repeat distance between adjacent channels still clearly give recognizable images of the present ultra-large pore materials.

The most regular preparations of the preferred material of the invention give a hexagonal X-ray

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diffraction pattern with a few distinct maxima in the extreme low angle region. The X-ray diffraction pattern, however, is not always a sufficient indicator of the presence of these materials, as the degree of regularity in the microstructure and the extent of repetition of the structure within individual particles affect the number of peaks that will be observed. Indeed, preparations with only one distinct peak in the low angle region of the X-ray diffraction pattern have been found to contain substantial amounts of the material of the invention.

In its calcined form, the crystalline material of the invention may be further characterized by an X-ray diffraction pattern with at least one peak at a position greater than about 1.8 nm d-spacing (4.909 degrees two-theta for Cu K-alpha radiation) which corresponds to the d_{100} value of the electron diffraction pattern of the material.

More preferably, the calcined crystalline material of the invention is characterized by an X-ray diffraction pattern with at least two peaks at positions greater than about 1 nm d-spacing (8.842 degrees two-theta for Cu K-alpha radiation), at least one of which is at a position greater than 1.8 nm d-spacing, and no peaks at positions less than 1 nm d-spacing with relative intensity greater than about 20% of the strongest peak. Still more particularly, the X-ray diffraction pattern of the calcined material of this invention has no peaks at positions less than 1 nm d-spacing with relative intensity greater than about 10% of the strongest peak. In the preferred hexagonal arrangement, at least one peak in the X-ray pattern will have a d-spacing corresponding to the d_{100} value of the electron diffraction pattern of the material.

X-ray diffraction data referred to herein were collected on a Scintag PAD X automated diffraction system employing theta-theta geometry, Cu K-alpha

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radiation, and an energy dispersive X-ray detector. Use of the energy dispersive X-ray detector eliminated the need for incident or diffracted beam monochromators. Both the incident and diffracted X-ray beams were collimated by double slit incident and diffracted collimation systems. The slit sizes used, starting from the X-ray tube source, were 0.5, 1.0, 0.3 and 0.2 mm, respectively. Different slit systems may produce differing intensities for the peaks. The materials of the present invention that have the largest pore sizes may require more highly collimated incident X-ray beams in order to resolve the low angle peak from the transmitted incident X-ray beam.

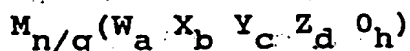
The diffraction data were recorded by step-scanning at 0.04 degrees of two-theta, where theta is the Bragg angle, and a counting time of 10 seconds for each step. The interplanar spacings, d's, were calculated in nanometers (nm), and the relative intensities of the lines, I/I_0 , where I_0 is one-hundredth of the intensity of the strongest line, above background, were derived with the use of a profile fitting routine. The intensities were uncorrected for Lorentz and polarization effects. The relative intensities are given in terms of the symbols vs = very strong (75-100), s = strong (50-74), m = medium (25-49) and w = weak (0-24). It should be understood that diffraction data listed as single lines may consist of multiple overlapping lines which under certain conditions, such as very high experimental resolution or crystallographic changes, may appear as resolved or partially resolved lines. Typically, crystallographic changes can include minor changes in unit cell parameters and/or a change in crystal symmetry, without a substantial change in structure. These minor effects, including changes in relative intensities, can also occur as a result of differences in cation content, framework composition, nature and

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degree of pore filling, thermal and/or hydrothermal history, and peak width/shape variations due to particle size/shape effects, structural disorder or other factors known to those skilled in the art of X-ray diffraction.

The material of the invention exhibits an equilibrium benzene adsorption capacity of greater than about 15 grams benzene/100 grams crystal at 6.7 kPa (50 torr) and 25°C. The equilibrium benzene adsorption capacity must, of course, be measured on a sample which exhibits no pore blockage by incidental contaminants. For example, water should be removed by dehydration techniques, e.g. thermal treatment, whereas inorganic amorphous materials, e.g. silica, and organics should be removed by contact with acid or base or other chemical agents and/or physical methods (such as, calcination) so that the detrital material is removed without detrimental effect on the material of the invention.

In general, crystalline material of this invention has the following composition:



wherein W is a divalent element, such as a divalent first row transition metal, e.g. manganese, cobalt, nickel, iron, and/or magnesium, preferably cobalt; X is a trivalent element, such as aluminum, boron, chromium, iron and/or gallium, preferably aluminum; Y is a tetravalent element such as silicon and/or germanium, preferably silicon; Z is a pentavalent element, such as phosphorus; M is one or more ions, such as, for example, ammonium, Group IA, IIA and VIIB ions, usually hydrogen, sodium and/or fluoride ions; n is the charge of the composition excluding M expressed as oxides; q is the weighted molar average valence of M; n/q is the number of moles or mole fraction of M; a, b, c, and d

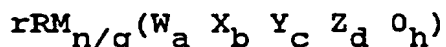
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are mole fractions of W, X, Y and Z, respectively; h is a number of from 1 to 2.5; and $(a+b+c+d) = 1$.

A preferred embodiment of the above crystalline material is when $(a+b+c)$ is greater than d, and $h = 2$.

5 More preferably, when $h = 2$, $a = 0$ and $d = 0$.

In the as-synthesized form, the material of this invention has a composition, on an anhydrous basis, expressed empirically as follows:



10 wherein R is the total organic material used to assist in the synthesis of the material and not included in M as an ion, and r is the coefficient for R, i.e. the number of moles or mole fraction of R.

The M and R components are associated with the material as a result of their presence during crystallization, and are easily removed or, in the case of M, replaced by post-crystallization methods hereinafter more particularly described. For example, the original M, e.g. sodium or chloride, ions of the as-synthesized material of this invention can be replaced by ion exchange with other ions. Preferred replacing ions include metal ions, hydrogen ions, hydrogen precursor, e.g. ammonium, ions and mixtures thereof. Particularly preferred ions are those which tailor the catalytic activity for certain hydrocarbon conversion reactions. These include hydrogen, rare earth metals and metals of Groups IA (e.g. K), IIA (e.g. Ca), VIIA (e.g. Mn), VIIIA (e.g. Ni), IB (e.g. Cu), IIB (e.g. Zn), IIIB (e.g. In), IVB (e.g. Sn), and VIIB (e.g. F) of the Periodic Table of the Elements (Sargent-Welch Scientific Co. Cat. No. S-18806, 1979) and mixtures thereof.

Materials having the composition defined by the above formula can be prepared from a reaction mixture having a composition in terms of mole ratios of oxides, within the following ranges:

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	<u>Reactants</u>	<u>Useful</u>	<u>Preferred</u>
	X_2O_3/YO_2	0 to 0.5	0.001 to 0.5
	$X_2O_3/(YO_2+Z_2O_5)$	0.1 to 100	0.1 to 20
5	$X_2O_3/(YO_2+WO+Z_2O_5)$	0.1 to 100	0.1 to 20
	Solvent/ $(YO_2+WO+Z_2O_5+X_2O_3)$	1 to 1500	5 to 1000
	OH^-/YO_2	0 to 10	0 to 5
	$(M_{2/e}O+R_{2/f}O)/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.01 to 20	0.05 to 5
10	$M_{2/e}O/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0 to 10	0 to 5
	$R_{2/f}O/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.01 to 2.0	0.03 to 1.0

wherein e and f are the weighted average valences of M and R, respectively, wherein the solvent is a C_1 to C_6 alcohol or diol, or, more preferably, water and wherein R comprises an organic directing agent having the formula $R_1R_2R_3R_4Q^+$ wherein Q is nitrogen or phosphorus and wherein at least one of R_1 , R_2 , R_3 and R_4 is aryl or alkyl group having 6 to 36 carbon atoms, e.g. $-C_6H_{13}$, $-C_{10}H_{21}$, $-C_{16}H_{33}$ and $-C_{18}H_{37}$, and each of the remainder of R_1 , R_2 , R_3 and R_4 is selected from hydrogen and an alkyl group having 1 to 5 carbon atoms. The compound from which the above ammonium or phosphonium ion is derived may be, for example, the hydroxide, halide, silicate or mixtures thereof.

The particular effectiveness of the above directing agent, when compared with other such agents known to direct synthesis of one or more other crystal structures, is believed due to its ability to function as a template in the nucleation and growth of the desired ultra-large pore materials. Non-limiting examples of these directing agents include cetyltrimethylammonium, cetyltrimethylphosphonium,

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octadecyltrimethylphosphonium, benzyltrimethylammonium, cetylpyridinium, myristyltrimethylammonium, decyltrimethylammonium, dodecyltrimethylammonium and dimethyldidodecylammonium compounds.

5 Preferably, the total organic, R, present in the reaction mixture comprises an additional organic directing agent in the form of an ammonium or phosphonium ion of the above directing agent formula but wherein each R_1 , R_2 , R_3 and R_4 is selected from
10 hydrogen and an alkyl group of 1 to 5 carbon atoms (2 of the alkyl groups can be interconnected to form a cyclic compound). Examples of the additional organic directing agent include tetramethylammonium, tetraethylammonium, tetrapropylammonium,
15 tetrabutylammonium and pyrrolidinium compounds. The molar ratio of the first-mentioned organic directing agent to the additional organic directing agent can be in the range 100/1 to 0.01/1. Where the additional organic directing agent is present, the molar ratio
20 $R_2/fO/(YO_2+WO+Z_2O_5+X_2O_3)$ in the reaction mixture is preferably 0.1 to 2.0, most preferably 0.12 to 1.0.

In addition, to vary the pore size of the final crystalline phase material, the total organic, R, in the reaction mixture can include an auxiliary organic
25 in addition to the organic directing agent(s) described above. This auxiliary organic is selected from (1) aromatic hydrocarbons and amines having 5-20 carbon atoms and halogen- and C_1 - C_{14} alkyl-substituted derivatives thereof, (2) cyclic and polycyclic
30 aliphatic hydrocarbons and amines of 5 to 20 carbon atoms and halogen- and C_1 - C_{14} alkyl-substituted derivatives thereof and (3) straight and branched chain aliphatic hydrocarbons and amines having 3-16 carbon atoms and halogen-substituted derivatives thereof.

35 In the above auxiliary organics, the halogen substituent is preferably bromine. The C_1 - C_{14} alkyl substituent may be a linear or branched aliphatic

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chain, such as, for example, methyl, ethyl, propyl, isopropyl, butyl, pentyl and combinations thereof. Examples of these auxiliary organics include, for example, p-xylene, trimethylbenzene, triethylbenzene and triisopropylbenzene.

With the inclusion of the auxiliary organic in the reaction mixture, the mole ratio of auxiliary organic/ YO_2 will be from 0.05 to 20, preferably from 0.1 to 10, and the mole ratio of auxiliary organic/organic directing agent(s) will be from 0.02 to 100, preferably from 0.05 to 35.

When a source of silicon is used in the synthesis method, it is preferred to use at least in part an organic silicate, such as, for example, a quaternary ammonium silicate. Non-limiting examples of such a silicate include tetramethylammonium silicate and tetraethylorthosilicate.

Non-limiting examples of various combinations of W, X, Y and Z contemplated for the above reaction mixture include:

	<u>W</u>	<u>X</u>	<u>Y</u>	<u>Z</u>
	--	Al	Si	--
	--	Al	--	P
	--	Al	Si	P
25	Co	Al	--	P
	Co	Al	Si	P
	--	--	Si	--

including the combinations of W being Mg, or an element selected from the divalent first row transition metals, e.g. Mn, Co and Ni; X being B, Ga or Fe; and Y being Ge.

To produce the crystalline material of the invention, the reaction mixture described above is maintained at a temperature of 25 to 250°C, preferably 50 to 175°C, and preferably a pH of 9 to 14 for a period of time until the required crystals form,

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typically 5 minutes to 14 days, more preferably 1 to 300 hours.

When the crystalline material of the invention is an aluminosilicate, the synthesis method conveniently involves the following steps:

(1) Mix the organic (R) directing agent with the solvent or solvent mixture such that the mole ratio of solvent/ $R_{2/f}O$ is within the range of 50 to 800, preferably from 50 to 500. This mixture constitutes the "primary template" for the synthesis method.

(2) To the primary template mixture of step (1) add the silica and alumina such that the ratio of $R_{2/f}O/(SiO_2 + Al_2O_3)$ is within the range 0.01 to 2.0.

(3) Agitate the mixture resulting from step (2) at a temperature of 20 to 40°C, preferably for 5 minutes to 3 hours.

(4) Allow the mixture to stand with or without agitation, preferably at 20 to 50°C, and preferably for 10 minutes to 24 hours.

(5) Crystallize the product from step (4) at a temperature of 50 to 150°C, preferably for 1 to 72 hours.

When used as a sorbent or catalyst component, the composition of the invention should be subjected to treatment to remove part or all of any organic constituent. The present composition can also be used as a catalyst component in intimate combination with a hydrogenating component such as tungsten, vanadium, molybdenum, rhenium, nickel, cobalt, chromium, manganese, or a noble metal such as platinum or palladium or mixtures thereof where a hydrogenation-dehydrogenation function is to be performed. Such component can be in the composition by way of co-crystallization, exchanged into the composition to the extent a Group IIIB element, e.g. aluminum, is in the structure, impregnated therein or intimately physically admixed therewith. Such

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component can be impregnated in or on to it such as, for example, by, in the case of platinum, treating the silicate with a solution containing a platinum metal-containing ion. Thus, suitable platinum compounds for this purpose include chloroplatinic acid, platinumous chloride and various compounds containing the platinum amine complex.

The above crystalline material, especially in its metal, hydrogen and ammonium forms can be beneficially converted to another form by thermal treatment (calcination). This thermal treatment is generally performed at a temperature of 400 to 750°C for at least 1 minute and generally not longer than 20 hours, preferably from 1 to 10 hours. While subatmospheric pressure can be employed for the thermal treatment, atmospheric pressure is desired for reasons of convenience, such as in air, nitrogen and ammonia. The thermally treated product is particularly useful in the catalysis of certain hydrocarbon conversion reactions.

The crystalline material of this invention, when employed either as an adsorbent or as a catalyst component in an organic compound conversion process should be dehydrated, at least partially. This can be done by heating to a temperature in the range of 200°C to 595°C in an atmosphere such as air, nitrogen, etc. and at atmospheric, subatmospheric or superatmospheric pressures for between 30 minutes and 48 hours.

Dehydration can also be performed at room temperature merely by placing the composition in a vacuum, but a longer time is required to obtain a sufficient amount of dehydration.

The present compositions are useful as catalyst components for catalyzing the conversion of organic compounds, e.g. oxygenates and hydrocarbons, by acid-catalyzed reactions. The size of the pores is such that the spatioselectivity with respect to transition state species is minimized in reactions

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such as cracking (see Chen et al., "Shape Selective Catalysis in Industrial Applications", 36 CHEMICAL INDUSTRIES, pgs. 41-61 (1989)). Diffusional limitations are also minimized as a result of the very large pores in the present materials. For these reasons, the present compositions are especially useful for catalyzing reactions which occur in the presence of acidic sites on the surface of the catalyst and which involve reactants, products or transitional state species which have large molecular sizes, too great to undergo similar reactions with conventional large pore size solid catalysts, for example, large pore size zeolites such as zeolite X, Y, L, ZSM-4, ZSM-18, and ZSM-20.

Thus, the present catalytic compositions are particularly useful in the conversion of organic compounds of large molecular size such as highly aromatic hydrocarbons with substituted or unsubstituted polycyclic aromatic components, bulky naphthenic compounds or highly substituted compounds with bulky steric configurations, e.g. molecular sizes of 1.3 nm or more. The present catalytic compositions are particularly useful for reactions in which the molecular weight of the feed is reduced to a lower value, i.e. cracking or hydrocracking. Cracking may be conducted at a temperature of 200 to 800°C, a pressure of atmospheric to 100 psig (100 to 800 kPa) and contact time of 0.1 second to 60 minutes. Hydrocracking may be conducted at a temperature of 150 to 550°C, a pressure of 100 to 3000 psig (800 to 20800 kPa), and a weight hourly space velocity of 0.1 to 100, with a hydrogen/hydrocarbon molar ratio of 0.1 to 100.

The present catalytic compositions are especially useful for reactions using high molecular weight, high boiling or non-distillable feeds, especially residual feeds, i.e. feeds which are essentially non-distillable or feeds which have an initial boiling point (5% point)

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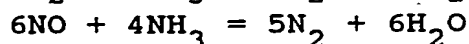
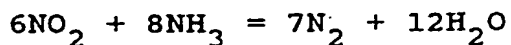
above 1050°F (565°C). Residual feeds which may be used with the present catalytic compositions include feeds with API gravities below about 20, usually below 15 and typically from 5 to 10 with Conradson Carbon Contents (CCR) of at least 1% by weight and more usually at least 5% or more, e.g. 5-10%. In some resid fractions the CCR may be as high as about 20 weight percent or even higher. The aromatic contents of these feeds will be correspondingly high, as may the contents of heteroatoms such as sulfur and nitrogen, as well as metals. Aromatics content of these feeds will usually be at least 50 weight percent and typically much higher, usually at least 70 or 80 weight percent, with the balance being principally naphthenes and heterocyclics. Typical petroleum refinery feeds of this type include atmospheric and vacuum tower resids, asphalts, aromatic extracts from solvent extraction processes, e.g. phenol or furfural extraction, deasphalted oils, slop oils and residual fractions from various processes such as lube production, coking and the like. High boiling fractions with which the present catalytic compositions may be used include gas oils, such as atmospheric gas oils; vacuum gas oils; cycle oils, especially heavy cycle oil; deasphalted oils; solvent extracts, such as bright stock; and heavy gas oils, such as coker heavy gas oils. The present catalytic materials may also be utilized with feeds of non-petroleum origin, for example, synthetic oils produced by coal liquefaction, Fischer-Tropsch waxes and heavy fractions and other similar materials.

The catalytic compositions of matter according to the present invention may also be used for selective conversion of inorganic compounds such as oxides of nitrogen in mixtures of gases which contain nitrogen oxides (NO_x), for example, industrial exhaust gases and the gases formed during the oxidative regeneration of catalysts used in the processing of hydrocarbons,

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especially in catalytic cracking operations. The porous crystalline material may be used in a matrixed or unmatrixed form for this purpose and may suitably be formed into extrudates, pellets or other shapes to permit the passage of gases over the catalyst with the minimum pressure drop. The crystalline material is preferably at least partly in the hydrogen form, but it may advantageously contain a minor amount of a noble metal as a catalytic component, especially a metal of Periods 5 and 6 of Group VIIIA of the Periodic Table, especially platinum, palladium, ruthenium, rhodium, iridium or mixtures thereof. Amounts of noble metal up to about 1 weight percent are typical with lower amounts, e.g. up to 0.1 or 0.5 weight percent being preferred.

The NO_x reduction is suitably conducted by passing the gas containing the oxides of nitrogen over the catalyst at an elevated temperature, typically at least 200°C, and usually within the range of 200 to 600°C. The gas mixture may be mixed with ammonia to promote reduction of the oxides of nitrogen and pre-mixing may be conducted at a temperature of up to about 200°C. The amount of ammonia which is mixed with the gas mixture is typically within the range of 0.75 to 1.25 the stoichiometric amount, which itself varies according to the ratio of the different oxides of nitrogen in the gas mixture, as shown by the equations:



The crystalline material of the invention may also be used for the reduction of oxides of nitrogen in gaseous mixtures in the presence of other reducing agents such as carbon or carbon monoxide. Reduction of the oxides of nitrogen in this way is of particular utility in the regeneration of fluid catalytic cracking (FCC) catalysts, since regeneration under appropriate conditions will produce the required concentrations of

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carbon monoxide which may then be used to reduce the proportion of NO_x in the regeneration gases in the presence of the catalyst.

5 The compositions of this invention can also be used as adsorbents and separation vehicles in pharmaceutical and fine chemical applications. For example, these ultra-large pore compositions may be used in the purification of drugs like insulin or be used as solid vehicles for the controlled delivery of
10 drugs. Another application for use of these ultra-large pore materials involves waste disposal where the extraordinary pore volumes are exploited. Therefore, at least one component can be partially or substantially totally separated from a mixture of
15 components having differential sorption characteristics with respect to the present ultra-large pore composition by contacting the mixture with the composition to selectively sorb the one component. Examples of this include contacting a mixture
20 comprising water and at least one hydrocarbon component, whereby the at least one hydrocarbon component is selectively sorbed. Another example includes selective sorption of at least one hydrocarbon component from a mixture comprising same and at least
25 one additional hydrocarbon component.

When used as a catalyst, it may be desirable to incorporate the crystalline composition of the invention with another material resistant to the temperatures and other conditions employed in organic
30 conversion processes. Such materials include active and inactive materials and synthetic or naturally occurring zeolites as well as inorganic materials such as clays, silica and/or metal oxides such as alumina, titania and/or zirconia. The latter may be either
35 naturally occurring or in the form of gelatinous precipitates or gels including mixtures of silica and metal oxides. Use of a material in conjunction with

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the new crystal, i.e. combined therewith or present during synthesis of the new crystal, which is active, tends to change the conversion and/or selectivity of the catalyst in certain organic conversion processes.

5 Inactive materials suitably serve as diluents to control the amount of conversion in a given process so that products can be obtained economically and orderly without employing other means for controlling the rate of reaction. These materials may be incorporated with
10 naturally occurring clays, e.g. bentonite and kaolin, to improve the crush strength of the catalyst under commercial operating conditions. Said materials, i.e. clays, oxides, etc., function as binders for the catalyst. It is desirable to provide a catalyst having
15 good crush strength because in commercial use it is desirable to prevent the catalyst from breaking down into powder-like materials. These clay binders have been employed normally only for the purpose of improving the crush strength of the catalyst.

20 Naturally occurring clays which can be composited with the new crystal include the montmorillonite and kaolin family, which families include the subbentonites, and the kaolins commonly known as Dixie, McNamee, Georgia and Florida clays or others in which
25 the main mineral constituent is halloysite, kaolinite, dickite, nacrite, or anauxite. Such clays can be used in the raw state as originally mined or initially subjected to calcination, acid treatment or chemical modification.

30 In addition to the foregoing materials, the new crystal can be composited with a porous matrix material such as silica-alumina, silica-magnesia, silica-zirconia, silica-thoria, silica-beryllia, silica-titania as well as ternary compositions such as
35 silica-alumina-thoria, silica-alumina-zirconia, silica-alumina-magnesia and silica-magnesia-zirconia.

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It may be desirable to provide at least a part of the foregoing matrix materials in colloidal form so as to facilitate extrusion of the bound catalyst components(s).

5 The relative proportions of finely divided crystalline material and inorganic oxide matrix vary widely, with the crystal content ranging from 1 to 90 percent by weight and more usually, particularly when
10 the composite is prepared in the form of beads, in the range 2 to 80 weight percent of the composite.

The invention will now be more particularly described with reference to the Examples and the accompanying drawings, in which:

15 Figures 1-14 are X-ray diffraction patterns of products of Examples 1-13 and 15, respectively.

Figure 15 is an isotherm plot of physisorption measurements from Example 21.

20 Figure 16 is a plot of physisorption measurements from Example 21 showing pore sizes of various crystalline materials.

Figure 17 is an electron diffraction pattern of the product of Example 4.

Figure 18 is a transmission electron micrograph of the product of Example 4.

25 Figure 19 is a transmission electron micrograph of the product of Example 5.

Figure 20 is a transmission electron micrograph of the product of Example 18.

30 Figure 21 is an X-ray diffraction pattern of the product of Example 23.

Figure 22 shows the effect of auxiliary organic on the d-spacing of the first X-ray diffraction maxima for Examples 23-31.

35 Figure 23 is a plot of pore size versus X-ray d-spacing for the products of Examples 23, 25, 26, 28, 29 and 31.

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Figure 24 is a plot of pore volume versus X-ray d-spacing for the products of Examples 23, 25, 26, 28, 29 and 31.

Figures 25-28 are X-ray diffraction patterns of the products of Examples 46-49 respectively.

In the examples, whenever sorption data are set forth for comparison of sorptive capacities for water, cyclohexane, benzene and/or n-hexane, they are Equilibrium Adsorption values determined as follows:

A weighed sample of the adsorbent, after calcination at about 540°C for at least about 1 hour and other treatment, if necessary, to remove any pore blocking contaminants, is contacted with the desired pure adsorbate vapor in an adsorption chamber. The increase in weight of the adsorbent is calculated as the adsorption capacity of the sample in terms of grams/100 grams adsorbent based on adsorbent weight after calcination at about 540°C. The present composition exhibits an equilibrium benzene adsorption capacity at 50 Torr (6.7 kPa) and 25°C of greater than about 15 grams/100 grams, particularly greater than about 17.5 g/100 g/ and more particularly greater than about 20 g/100 g.

A preferred way to measure adsorption capacity is to contact the material of the invention with the desired pure adsorbate vapor in an adsorption chamber evacuated to less than 1 mm. The pressure is kept constant (within about ± 0.5 mm) by addition of adsorbate vapor controlled by a manostat during the adsorption period. As adsorbate is adsorbed by the new crystal, the decrease in pressure causes the manostat to open a valve which admits more adsorbate vapor to the chamber to restore the above control pressures. Sorption is complete when the pressure change is not sufficient to activate the manostat.

Another way to measure benzene adsorption is on a suitable thermogravimetric analysis system, such as a

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computer-controlled 990/951 duPont TGA system. The adsorbent sample is dehydrated (physically sorbed water removed) by heating at, for example, about 350°C or 500°C to constant weight in flowing helium. If the sample is in as-synthesized form, e.g. containing organic directing agents, it is calcined at about 540°C in air and held to constant weight instead of the previously described 350°C or 500°C treatment. Benzene adsorption isotherms are measured at 25°C by blending a benzene saturated helium gas stream with a pure helium gas stream in the proper proportions to obtain the desired benzene partial pressure. The value of the adsorption at 50 Torr (6.7 kPa) of benzene is taken from a plot of the adsorption isotherm.

EXAMPLE 1

One hundred grams of cetyltrimethylammonium (CTMA) hydroxide solution, prepared by contacting a 29 wt.% N,N,N-trimethyl-1-hexadecanaminium chloride solution with a hydroxide-for-halide exchange resin, was combined with 100 grams of an aqueous solution of tetramethylammonium (TMA) silicate (10% silica) with stirring. Twenty-five grams of HiSil, a precipitated hydrated silica containing about 6 wt.% free water and about 4.5 wt.% bound water of hydration and having an ultimate particle size of about 0.02 micron, was added. The resulting mixture was placed in a polypropylene bottle, which was kept in a steam box at 95°C overnight. The mixture had a composition in terms of moles per mole Al_2O_3 :

2.7 moles Na_2O
392 moles SiO_2
35.7 moles $(\text{CTMA})_2\text{O}$
61.7 moles $(\text{TMA})_2\text{O}$
6231 moles H_2O

The resulting solid product was recovered by filtration and dried in air at ambient temperature.

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The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

The calcined product proved to have a surface area of 475 m²/g and the following equilibrium adsorption capacities in grams/100 grams:

H ₂ O	8.3
Cyclohexane	22.9
n-Hexane	18.2
Benzene	21.5

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 1. In this and the following Figures, it is noted that 10 Angstrom Units (1.0 nm) d-spacing corresponds to 8.842 degrees 2-theta (Cu K-alpha radiation) and 18 Angstrom Units (1.8 nm) corresponds to 4.909 degrees.

The product of this example may be characterized as including a very strong relative intensity line at 3.78 ± 0.2 nm d-spacing, and weak lines at 2.16 ± 0.1 and 1.92 ± 0.1 nm. The present ultra-large pore material was demonstrated to be in the product of this example by transmission electron microscopy (TEM), which produced images of a hexagonal arrangement of uniform pores and hexagonal electron diffraction pattern with a d₁₀₀ value of 3.9 nm.

25

EXAMPLE 2

One hundred grams of cetyltrimethylammonium (CTMA) hydroxide solution prepared as in Example 1 was combined with 100 grams of an aqueous solution of tetramethylammonium (TMA) hydroxide (25%) with stirring. Twenty-five grams of HiSil, a precipitated hydrated silica containing about 6 wt.% free water and about 4.5 wt.% bound water of hydration and having an ultimate particle size of about 0.02 micron, was added. The resulting mixture was placed in a static autoclave at 150°C overnight. The mixture had a composition in terms of moles per mole Al₂O₃:

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2.7 moles Na_2O
291 moles SiO_2
35.7 moles $(\text{CTMA})_2\text{O}$
102 moles $(\text{TMA})_2\text{O}$
5 6120 moles H_2O

The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

10 The calcined product proved to have a surface area of $993 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in grams/100 grams:

15	H_2O	7.1
	Cyclohexane	47.2
	n-Hexane	36.2
	Benzene	49.5

20 The X-ray diffraction pattern of the calcined product of this example is shown in Figure 2. It may be characterized as including a very strong relative intensity line at $3.93 \pm 0.2 \text{ nm}$ d-spacing, and weak lines at 2.22 ± 0.1 and $1.94 \pm 0.1 \text{ nm}$. TEM indicated that the product contained the present ultra-large pore material.

25 A portion of the above product was then contacted with 100% steam at 790°C (1450°F) for two hours. The surface area of the steamed material was measured to be $440 \text{ m}^2/\text{g}$, indicating that about 45% was retained following severe steaming.

30 Another portion of the calcined product of this example was contacted with 100% steam at 680°C (1250°F) for two hours. The surface area of this material was measured to be $718 \text{ m}^2/\text{g}$, indicating that 72% was retained after steaming at these conditions.

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EXAMPLE 3

Water, cetyltrimethylammonium hydroxide solution prepared as in Example 1, aluminum sulfate, HiSil and an aqueous solution of tetrapropylammonium (TPA) bromide (35%) were combined to produce a mixture having a composition in terms of moles per mole Al_2O_3 :

0.65 moles Na_2O
65 moles SiO_2
8.8 moles $(\text{CTMA})_2\text{O}$
1.22 moles $(\text{TPA})_2\text{O}$
1336 moles H_2O

The resulting mixture was placed in a polypropylene bottle, which was kept in a steam box at 95°C for 192 hours. The sample was then cooled to room temperature and combined with CTMA hydroxide solution prepared as in Example 1 and TMA hydroxide (25% by weight) in the weight ratio of 3 parts mixture, 1 part CTMA hydroxide and 2 parts TMA hydroxide. The combined mixture was then placed in a polypropylene bottle and kept in a steam box at 95°C overnight. The combined mixture had a composition in terms of moles per mole Al_2O_3 :

0.65 moles Na_2O
65 moles SiO_2
15 moles $(\text{CTMA})_2\text{O}$
1.22 moles $(\text{TPA})_2\text{O}$
35.6 moles $(\text{TMA})_2\text{O}$
2927 moles H_2O

The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

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The calcined product proved to have a surface area of $1085 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in grams/100 grams:

	H_2O	11.5
5	Cyclohexane	> 50
	n-Hexane	39.8
	Benzene	62

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 3. The product of this example may be characterized as including a very strong relative intensity line at $3.82 \pm 0.2 \text{ nm}$ d-spacing, and weak lines at 2.22 ± 0.1 and $1.94 \pm 0.1 \text{ nm}$. TEM indicated the product contained the present ultra-large pore material.

15

EXAMPLE 4

Two hundred grams of cetyltrimethylammonium (CTMA) hydroxide solution prepared as in Example 1 was combined with 2 grams of Catapal alumina (alpha-alumina monohydrate, 74% alumina) and 100 grams of an aqueous solution of tetramethylammonium (TMA) silicate (10% silica) with stirring. Twenty-five grams of HiSil, a precipitated hydrated silica containing about 6 wt.% free water and about 4.5 wt.% bound water of hydration and having an ultimate particle size of about 0.02 micron, was added. The resulting mixture was placed in a static autoclave at 150°C for 48 hours. The mixture had a composition in terms of moles per mole Al_2O_3 :

30

0.23 moles Na_2O
33.2 moles SiO_2
6.1 moles $(\text{CTMA})_2\text{O}$
5.2 moles $(\text{TMA})_2\text{O}$
780 moles H_2O

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The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

5 The calcined product proved to have a surface area of 1043 m²/g and the following equilibrium adsorption capacities in grams/100 grams:

	H ₂ O	6.3
	Cyclohexane	> 50
10	n-Hexane	49.1
	Benzene	66.7

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 4. It may be characterized as including a very strong relative intensity line at 4.08 ± 0.2 nm d-spacing, and weak lines at 2.31 ± 0.1 and 2.01 ± 0.1 nm. TEM indicated that the product contained the present ultra-large pore material (see Example 22).

EXAMPLE 5

20 Two-hundred sixty grams of water was combined with 77 grams of phosphoric acid (85%), 46 grams of Catapal alumina (74% alumina), and 24 grams of pyrrolidine (Pyr) with stirring. This first mixture was placed in a stirred autoclave and heated to 150°C for six days.

25 The material was filtered, washed and air-dried. Fifty grams of this product was slurried with 200 grams of water and 200 grams of cetyltrimethylammonium hydroxide solution prepared as in Example 1. Four hundred grams of an aqueous solution of tetraethylammonium silicate

30 (10% silica) was then added to form a second mixture which was placed in a polypropylene bottle and kept in a steam box at 95°C overnight. The first mixture had a composition in terms of moles per mole Al₂O₃:

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1.0 moles P_2O_5
0.51 moles $(Pyr)_2O$
47.2 moles H_2O

5 The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at $540^\circ C$ for 1 hour in nitrogen, followed by 6 hours in air.

10 The calcined product proved to have a surface area of $707 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in grams/100 grams:

H_2O	33.2
Cyclohexane	19.7
n-Hexane	20.1
Benzene	23.3

15 The X-ray diffraction pattern of the calcined product of this example is shown in Figure 5. It may be characterized as including a very strong relative intensity line at $2.54 \pm 0.15 \text{ nm}$ d-spacing. TEM indicated the product contained the present ultra-large
20 pore material (see Example 22).

EXAMPLE 6

A solution of 1.35 grams of $NaAlO_2$ (43.5% Al_2O_3 , 30% Na_2O) dissolved in 45.2 grams of water was mixed with 17.3 grams of $NaOH$, 125.3 grams of colloidal
25 silica (40%, Ludox HS-40) and 42.6 grams of 40% aqueous solution of tetraethylammonium (TEA) hydroxide. After stirring overnight, the mixture was heated for 7 days in a steam box ($95^\circ C$). Following filtration, 151 grams of the solution was mixed with 31 grams of
30 cetyltrimethylammonium hydroxide solution prepared as in Example 1 and stored in the steam box at $95^\circ C$ for 13 days. The mixture had the following relative molar composition:

- 30 -

0.25 moles Al_2O_3
10 moles Na_2O
36 moles SiO_2
0.95 moles $(\text{CTMA})_2\text{O}$
2.5 moles $(\text{TEA})_2\text{O}$
445 moles H_2O

5
10 The resulting solid product was recovered by filtration and washed with water and ethanol. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

The calcined product composition included 0.14 wt.% Na, 68.5 wt.% SiO_2 and 5.1 wt.% Al_2O_3 , and proved to have a benzene equilibrium adsorption capacity of 58.6 grams/100 grams.

15 The X-ray diffraction pattern of the calcined product of this example is shown in Figure 6. The product of this example may be characterized as including a very strong relative intensity line at 3.14 ± 0.15 nm d-spacing. TEM indicated that the product
20 contained the present ultra-large pore material.

EXAMPLE 7

A mixture of 150 grams of cetyltrimethylammonium (CTMA) hydroxide solution prepared as in Example 1 and 21 grams of colloidal silica (40%, Ludox HS-40) with an
25 initial pH of 12.64 was heated in a 300 cc autoclave at 150°C for 48 hours with stirring at 200 rpm. The mixture had a composition in terms of moles per mole SiO_2 :

30 0.5 mole $(\text{CTMA})_2\text{O}$
46.5 moles H_2O

The resulting solid product was recovered by filtration, washed with water, then calcined at 540°C for 6 hours in air.

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The calcined product composition was measured to include 0.01 wt.% Na, 93.2 wt.% SiO_2 and 0.016 wt.% Al_2O_3 , and proved to have a surface area of $992 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in grams/100 grams:

H_2O	4.6
Cyclohexane	> 50
n-Hexane	> 50
Benzene	62.7

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 7. This product may be characterized as including a very strong relative intensity line at $4.36 \pm 0.2 \text{ nm}$ d-spacing and weak lines at 2.51 ± 0.15 and $2.17 \pm 0.1 \text{ nm}$. TEM indicated that the product contained the present ultra-large pore material.

EXAMPLE 8

Sodium aluminate (4.15g) was added slowly into a solution containing 16g of myristyltrimethylammonium bromide ($\text{C}_{14}\text{TMABr}$) in 100g of water. Tetramethylammonium silicate (100g-10% SiO_2), HiSil (25g) and tetramethylammonium hydroxide (14.2g-25% solution) were then added to the mixture. The mixture had the following relative molar composition:

1.9 moles Al_2O_3
3.0 moles Na_2O
54 moles SiO_2
2.4 moles $(\text{C}_{14}\text{TMA})_2\text{O}$
6.1 moles $(\text{TMA})_2\text{O}$
628 moles H_2O

The mixture was crystallized in an autoclave at 120°C with stirring for 24 hours. The resultant product was filtered, washed and air dried. Elemental analysis

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showed the product contained 53.3 wt% SiO_2 , 3.2 wt% Al_2O_3 , 15.0 wt% C, 1.88 wt% N, 0.11 wt% Na and 53.5 wt% ash at 1000°C. Figure 8 shows the X-ray diffraction pattern of the material having been calcined at 540°C for 1 hour in N_2 and 6 hours in air. The X-ray diffraction pattern includes a very strong relative intensity line at 3.53 ± 0.2 nm d-spacing and weak lines at 2.04 ± 0.1 and 1.77 ± 0.1 nm d-spacing. TEM indicated that the product contained the present ultra-large pore material.

The washed product, having been exchanged with 1N ammonium nitrate solution at room temperature, then calcined, proved to have a surface area of 827 m^2/g and the following equilibrium adsorption capacities in g/100g anhydrous sorbent:

H_2O	30.8
Cyclohexane	33.0
n-Hexane	27.9
Benzene	40.7

20

EXAMPLE 9

Sodium aluminate (8.3g) was added slowly into a solution containing 184g of dodecyltrimethylammonium hydroxide ($\text{C}_{12}\text{TMAOH}$, 50%) solution diluted with 480g of water. UltraSil (50g) and an aqueous solution of tetramethylammonium silicate (200g-10% SiO_2) and tetramethylammonium hydroxide (26.38g-25% solution) were then added to the mixture. The mixture had the following relative molar composition:

25

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0.36 moles Al_2O_3
 0.55 moles Na_2O
 11 moles SiO_2
 1.9 moles $(\text{C}_{12}\text{TMA})_2\text{O}$
 1.2 moles $(\text{TMA})_2\text{O}$
 394 moles H_2O
 11.1 moles isopropanol

The mixture was crystallized in an autoclave at 100°C with stirring for 24 hours. The resultant product was filtered, washed and air dried. Figure 9 shows the X-ray diffraction pattern of the material having been calcined at 540°C for 1 hour in N_2 and 6 hours in air. The X-ray diffraction pattern includes a very strong relative intensity line at 3.04 ± 0.15 nm d-spacing and weak lines at 1.77 ± 0.1 and 1.53 ± 0.1 nm d-spacing. TEM indicated that the product contained the present ultra-large pore material.

The washed product, having been exchanged with 1N ammonium nitrate solution at room temperature, then calcined, proved to have a surface area of $1078 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in g/100g anhydrous sorbent:

	H_2O	32.6
	Cyclohexane	38.1
25	n-Hexane	33.3
	Benzene	42.9

EXAMPLE 10

A solution of 4.9 grams of NaAlO_2 (43.5 % Al_2O_3 , 30% NaO_2) in 37.5 grams of water was mixed with 46.3 cc of 40% aqueous tetraethylammonium hydroxide solution and 96 grams of colloidal silica (40%, Ludox HS-40). The gel was stirred vigorously for 0.5 hour, mixed with an equal volume (150 ml) of cetyltrimethylammonium hydroxide solution prepared as in Example 1 and

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reacted at 100°C for 168 hours. The mixture had the following composition in terms of moles per mole Al_2O_3 :

5 1.1 moles Na_2O
 30.6 moles SiO_2
 3.0 moles $(\text{TEA})_2\text{O}$
 3.25 moles $(\text{CTMA})_2\text{O}$
 609 moles H_2O

10 The resulting solid product was recovered by filtration, washed with water then calcined at 540°C for 16 hours in air.

The calcined product proved to have a surface area of 1352 m^2/g and the following equilibrium adsorption capacities in grams/100 grams:

15 H_2O 23.6
 Cyclohexane >50
 n-Hexane 49
 Benzene 67.5

20 The X-ray diffraction pattern of the calcined product of this example is shown in Figure 10. The product of this example may be characterized as including a very strong relative intensity line at 3.85 ± 0.2 nm d-spacing and a weak line at 2.03 ± 0.1 nm: TEM indicated that the product contained the present ultra-large pore material.

25 EXAMPLE 11

30 Two hundred grams of cetyltrimethylammonium (CTMA) hydroxide solution prepared as in Example 1 was combined with 4.15 grams of sodium aluminate and 100 grams of aqueous tetramethylammonium (TMA) silicate solution (10% silica) with stirring. Twenty-five grams of HiSil, a precipitated hydrated silica containing about 6 wt.% free water and about 4.5 wt.% bound water of hydration and having an ultimate particle size of

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about 0.02 micron, was added. The resulting mixture was placed in a static autoclave at 150°C for 24 hours. The mixture had a composition in terms of moles per mole Al_2O_3 :

5 1.25 moles Na_2O
 27.8 moles SiO_2
 5.1 moles $(\text{CTMA})_2\text{O}$
 4.40 moles $(\text{TMA})_2\text{O}$
 650 moles H_2O

10 The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air. TEM indicated that this product contained the present ultra-large
15 pore material. The X-ray diffraction pattern of the calcined product of this example is shown in Figure 11. This pattern can be characterized as including a very strong relative intensity line at 4.42 ± 0.2 nm d-spacing and weak lines at 2.52 ± 0.15 and 2.2 ± 0.1
20 nm.

The calcined product proved to have a surface area of $932 \text{ m}^2/\text{g}$ and the following equilibrium adsorption capacities in grams/100 grams:

25	H_2O	39.3
	Cyclohexane	46.6
	n-Hexane	37.5
	Benzene	50

The product of this example was then ammonium exchanged with 1 N NH_4NO_3 solution, followed by
30 calcination at 540°C for 10 hours in air.

EXAMPLE 12

Two hundred grams of cetyltrimethylammonium (CTMA) hydroxide solution prepared as in Example 1 was

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combined with 4.15 grams of sodium aluminate and 100 grams of aqueous tetramethylammonium (TMA) silicate solution (10% silica) with stirring. Twenty-five grams of HiSil, a precipitated hydrated silica containing
5 about 6 wt.% free water and about 4.5 wt.% bound water of hydration and having an ultimate particle size of about 0.02 micron, was added. The resulting mixture was placed in a steam box at 100°C for 48 hours. The mixture had a composition in terms of moles per mole
10 Al_2O_3 :

1.25 moles Na_2O
27.8 moles SiO_2
5.1 moles $(\text{CTMA})_2\text{O}$
4.4 moles $(\text{TMA})_2\text{O}$
15 650 moles H_2O

The resulting solid product was recovered by filtration and dried in air at ambient temperature. The product was then calcined at 540°C for 1 hour in nitrogen, followed by 6 hours in air.

20 The calcined product proved to have the following equilibrium adsorption capacities in grams/100 grams:

H_2O	35.2
Cyclohexane	> 50
n-Hexane	40.8
25 Benzene	53.5

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 12. This product may be characterized as including a very strong relative intensity line at 3.91 ± 0.2 nm d-spacing and
30 weak lines at 2.24 ± 0.1 and 1.94 ± 0.1 nm. TEM indicated that this product contained the present ultra-large pore material.

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The product of this example was then ammonium exchanged with 1 N NH_4NO_3 solution, followed by calcination at 540°C for 10 hours in air.

EXAMPLE 13

5 A mixture of 125 grams of 29% CTMA chloride aqueous solution, 200 grams of water, 3 grams of sodium aluminate (in 50 grams H_2O), 65 grams of Ultrasil, amorphous precipitated silica available from PQ Corporation, and 21 grams NaOH (in 50 grams H_2O) was
10 stirred thoroughly and crystallized at 150°C for 168 hours. The reaction mixture had the following relative molar composition in terms of moles per mole silica:

0.10 moles $(\text{CTMA})_2\text{O}$
21.89 moles H_2O
15 0.036 moles NaAlO_2
0.53 moles NaOH

The solid product was isolated by filtration, washed with water, dried for 16 hours at room temperature and calcined at 540°C for 10 hours in air.

20 The calcined product proved to have a surface area of $840 \text{ m}^2/\text{g}$, and the following equilibrium adsorption capacities in grams/100 grams:

	H_2O	15.2
	Cyclohexane	42.0
25	n-Hexane	26.5
	Benzene	62

The X-ray diffraction pattern of the calcined product of this Example, shown in Figure 13, may be characterized as including a very strong relative
30 intensity line at $4.05 \pm 0.2 \text{ nm}$ d-spacing. TEM indicated that the product contained the present ultra-large pore material.

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EXAMPLE 14

For comparison purposes, a commercially prepared ultra-stable zeolite Y was obtained. It had a benzene equilibrium adsorption capacity of 20.7 grams/100 grams. Its X-ray diffraction pattern had all the lines of zeolite Y with its highest value peak at about 1.40 nm d-spacing.

EXAMPLE 15

To make the primary template mixture for this example, 240 grams of water was added to a 92 gram solution of 50% dodecyltrimethylammonium hydroxide; 36% isopropyl alcohol (IPA) and 14% water such that the mole ratio of Solvent/ $R_{2/f}O$ was 155. The mole ratio of $H_2O/R_{2/f}O$ in this mixture was 149 and the IPA/ $R_{2/f}O$ mole ratio was 6. To the primary template mixture was added 4.15 grams of sodium aluminate, 25 grams of HiSil, 100 grams of aqueous tetramethylammonium silicate solution (10% SiO_2) and 13.2 grams of 25% aqueous tetramethylammonium hydroxide solution. The mole ratio of $R_{2/f}O/(SiO_2+Al_2O_3)$ was 0.28 for the mixture.

This mixture was stirred at 25°C for 1 hour. The resulting mixture was then placed in an autoclave at 100°C and stirred at 100 rpm for 24 hours. The mixture in the autoclave had the following relative molar composition in terms of moles per mole SiO_2 :

	0.05 mole Na_2O
	0.036 mole Al_2O_3
35	0.18 mole $(C_{12}^{TMA})_2O$
	0.12 mole $(TMA)_2O$
	36.0 moles H_2O
	1.0 mole IPA

The resulting solid product was recovered by filtration, washed with water and dried in air at ambient temperature. The product was then calcined at

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540°C for 1 hour in nitrogen, followed by 6 hours in air.

The calcined product proved to have a surface area of 1223 m²/g and the following equilibrium adsorption capacities in grams/100 grams:

H ₂ O	25.5
Cyclohexane	41.1
n-Hexane	35.1
Benzene	51

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 14. This product may be characterized as including a very strong relative intensity line at 3.08 ± 0.15 nm d-spacing and weak lines at 1.79 ± 0.1 and 1.55 ± 0.1 nm. TEM indicated this product to contain the present ultra-large pore material.

EXAMPLE 16

A 50.75 gram quantity of decyltrimethylammonium hydroxide (prepared by contacting a ca. 29 wt.% solution of decyltrimethylammonium bromide with a hydroxide-for-halide exchange resin) was combined with 8.75 grams of tetraethylorthosilicate. The mixture was stirred for about 1 hour and then transferred to a polypropylene jar which was then placed in a steambox for about 24 hours. The mixture had a composition in terms of moles per mole SiO₂:

0.81 mole (C₁₀TMA)₂O
47.6 moles H₂O

The resulting solid product was filtered and washed several times with warm (60-70°C) distilled water and with acetone. The final product was calcined to 538°C in N₂/air mixture and then held in air for about 8 hours.

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The calcined product proved to have a surface area of $915 \text{ m}^2/\text{g}$ and an equilibrium benzene adsorption capacity of 35 grams/100 grams. Argon physisorption data indicated an argon uptake of 0.34 cc/gram, and a pore size of 1.5 nm.

The X-ray diffraction pattern of the calcined product of this example may be characterized as including a very strong relative intensity line at $2.75 \pm 0.15 \text{ nm}$ d-spacing and weak lines at 1.58 ± 0.1 and $1.37 \pm 0.1 \text{ nm}$. TEM indicated that the product of this example contained the present ultra-large pore material.

EXAMPLE 17

To eighty grams of cetyltrimethylammonium hydroxide (CTMAOH) solution prepared as in Example 1 was added 1.65 grams of NaAlO_2 . The mixture was stirred at room temperature until the NaAlO_2 was dissolved. To this solution was added 40 grams of aqueous tetramethylammonium (TMA) silicate solution (10 wt.% SiO_2), 10 grams of HiSil, 200 grams of water and 70 grams of 1,3,5-trimethylbenzene (TMB). The resulting mixture was stirred at room temperature for several minutes. The gel was then loaded into a 600 cc autoclave and heated at 105°C for sixty-eight hours with stirring at 150 rpm. The mixture had a composition in terms of moles per mole Al_2O_3 :

1.25 moles Na_2O
27.8 moles SiO_2
5.1 moles $(\text{CTMA})_2\text{O}$
2.24 moles $(\text{TMA})_2\text{O}$
2256 moles H_2O
80.53 moles TMB

The resulting product was filtered and washed several times with warm (60 – 70°C) distilled water and with acetone. The final product was calcined to 538°C

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in N₂/air mixture and then held in air for about 10 hours.

The calcined product proved to have an equilibrium benzene adsorption capacity of >25 grams/100 grams.

5 The X-ray diffraction pattern of the calcined product of this example may be characterized as including a broad, very strong relative intensity line at about 10.2 nm d-spacing, but accurate positions of lines in the extreme low angle region of the X-ray
10 diffraction pattern are very difficult to determine with conventional X-ray diffractometers. Furthermore, finer collimating slits were required to resolve a peak at this low 2-theta angle. The slits used in this
15 example, starting at the X-ray tube, were 0.1, 0.3, 0.5 and 0.2 mm, respectively. TEM indicated that the product of this example contained several materials with different d₁₀₀ values as observed in their electron diffraction patterns. These materials were found to possess d₁₀₀ values between 8.5 and 12 nm
20 d-spacing.

EXAMPLE 18

To eighty grams of cetyltrimethylammonium hydroxide (CTMAOH) solution prepared as in Example 1 was added 1.65 grams of NaAlO₂. The mixture was
25 stirred at room temperature until the NaAlO₂ was dissolved. To this solution was added 40 grams of aqueous tetramethylammonium (TMA) silicate solution (10 wt.% SiO₂), 10 grams of HiSil, 200 grams of water and 120 grams of 1,3,5-trimethylbenzene (TMB). The
30 resulting mixture was stirred at room temperature for several minutes. The gel was then loaded into a 600 cc autoclave and heated at 105°C for ninety hours with stirring at 150 rpm. The mixture had a composition in terms of moles per mole Al₂O₃:

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1.25 moles Na_2O
27.8 moles SiO_2
5.1 moles $(\text{CTMA})_2\text{O}$
2.24 moles $(\text{TMA})_2\text{O}$
2256 moles H_2O
132.7 moles TMB

5
10 The resulting product was filtered and washed several times with warm (60-70°C) distilled water and with acetone. The final product was calcined to 538°C in N_2 /air mixture and then held in air for about 10 hours.

15 The calcined product proved to have a surface area of $915 \text{ m}^2/\text{g}$ and an equilibrium benzene adsorption capacity of >25 grams/100 grams. Argon physisorption data indicated an argon uptake of 0.95 cc/gram, and a pore size centered on 7.8 nm (Dollimore-Heal Method, see Example 21(b)), but running from 7 to greater than 10.5 nm.

20 The X-ray diffraction pattern of the calcined product of this example may be characterized as having only enhanced scattered intensity in the very low angle region of the X-ray diffraction, where intensity from the transmitted incident X-ray beam is usually observed. However, TEM indicated that the product of this example contained several materials with different d_{100} values as observed in their electron diffraction patterns. These materials were found to possess d_{100} values between 8.5 and 11 nm d-spacing (see Example 22).

30

EXAMPLE 19

To eighty grams of cetyltrimethylammonium hydroxide (CTMAOH) solution prepared as in Example 1 was added 1.65 grams of NaAlO_2 . The mixture was stirred at room temperature until the NaAlO_2 was dissolved. To this solution was added 40 grams of aqueous tetramethylammonium (TMA) silicate solution (10

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wt.% SiO_2), 10 grams of HiSil, and 18 grams of 1,3,5-trimethylbenzene (TMB). The resulting mixture was stirred at room temperature for several minutes. The gel was then loaded into a 300 cc autoclave and
5 heated at 105°C for four hours with stirring at 150 rpm. The mixture had a composition in terms of moles per mole Al_2O_3 :

10
1.25 moles Na_2O
27.8 moles SiO_2
5.1 moles $(\text{CTMA})_2\text{O}$
2.24 moles $(\text{TMA})_2\text{O}$
650 moles H_2O
19.9 moles TMB

15 The resulting product was filtered and washed several times with warm (60 - 70°C) distilled water and with acetone. The final product was calcined to 538°C in N_2 /air mixture and then held in air for about 8 hours.

20 The calcined product proved to have a surface area of $975 \text{ m}^2/\text{g}$ and an equilibrium benzene adsorption capacity of >40 grams/100 grams. Argon physisorption data indicated an argon uptake of 0.97 cc/gram , and a pore size of 6.3 nm (Dollimore-Heal Method, see Example 21(b)), with the peak occurring at $P/P_0=0.65$.

25 The X-ray diffraction pattern of the calcined product of this example may be characterized as including a very strong relative intensity line at $6.3 \pm 0.5 \text{ nm}$ d-spacing and weak lines at 3.64 ± 0.2 , 3.13 ± 0.15 and $2.38 \pm 0.1 \text{ nm}$ d-spacing. TEM indicated that
30 the product of this example contained the present ultra-large pore material.

EXAMPLE 20

For catalytic evaluation of the present invention, final products from Examples 1 through 14 were

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evaluated for dealkylation of tri-tert-butylbenzene (TBB) to di-tert butylbenzene. The present evaluation was conducted under one or both of two sets of conditions: (i) at a temperature of 225°C, weight hourly space velocity of 100 hr⁻¹ or (ii) at a temperature of 200°C, weight hourly space velocity of 200 hr⁻¹. Pressure was atmospheric. The feed was composed of 6.3/93.7 TTBB/toluene. Conversion was measured at 30 minutes on stream.

The results were as follows:

	Catalyst of Example	Conversion, wt. %	
		225°C/100 hr ⁻¹	200°C/200 hr ⁻¹
15	1	0	--
	2	6.2	--
	3	53.9	--
	4	10.4	--
	5	68.9	--
20	6	100.0	--
	7	5.3	--
	8	--	61.2
	9	--	58.9
	10	86.3	--
25	11	96.7	--
	12	92.8	--
	13	--	37.7
	14	12.0	0

EXAMPLE 21(a)

Argon Physisorption For Pore Systems Up to About 6.0 nm Diameter

To determine the pore diameters of the products of this invention with pores up to about 6.0 nm in diameter, 0.2 gram samples of the products of Examples 1 through 16 were placed in glass sample tubes and attached to a physisorption apparatus as described in U.S. Patent No. 4,762,010.

The samples were heated to 300°C for 3 hours in vacuo to remove adsorbed water. Thereafter, the samples were cooled to 87°K by immersion of the sample tubes in liquid argon. Metered amounts of gaseous argon were then admitted to the samples in stepwise manner as described in U.S. Patent No. 4,762,010,

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column 20. From the amount of argon admitted to the samples and the amount of argon left in the gas space above the samples, the amount of argon adsorbed can be calculated. For this calculation, the ideal gas law and the calibrated sample volumes were used. (See also S.J. Gregg et al., Adsorption, Surface Area and Porosity, 2nd ed., Academic Press, 1982). In each instance, a graph of the amount adsorbed versus the relative pressure above the sample, at equilibrium, constitutes the adsorption isotherm as shown in Figure 15 for the Example 4 product sample. It is common to use relative pressures which are obtained by forming the ratio of the equilibrium pressure and the vapor pressure P_0 of the adsorbate at the temperature where the isotherm is measured. Sufficiently small amounts of argon were admitted in each step to generate 168 data points in the relative pressure range from 0 to 0.6. At least about 100 points are required to define the isotherm with sufficient detail.

The step (inflection) in the isotherm, in this case (Example 4 product) at about $P/P_0 = 0.4$, indicates filling of a pore system. The size of the step indicates the amount adsorbed, whereas the position of the step in terms of P/P_0 reflects the size of the pores in which the adsorption takes place. Larger pores are filled at higher P/P_0 . In order to better locate the position of the step in the isotherm, the derivative with respect to $\log (P/P_0)$ is formed. This is shown in Figure 16. Also shown in Figure 16 are data obtained in an identical fashion for a crystalline material from U.S. Patent No. 4,880,611 and several other crystal materials. There is further provided a physical scale on the axis which converts the position of an adsorption peak in terms of $\log (P/P_0)$ to the physical pore diameter. This conversion was obtained by using the following formula:

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$$\log(P/P_0) = \frac{K}{d-0.38} \left(\frac{S^4}{3(L-D/2)^3} - \frac{S^{10}}{9(L-D/2)^9} - \frac{S^4}{3(D/2)^3} + \frac{S^{10}}{9(D/2)^9} \right)$$

wherein d = pore diameter in nanometers, $K = 32.17$, $S = 0.2446$, $L = d + 0.19$, and $D = 0.57$.

5 This formula is derived from the method of Horvath and Kawazoe (G. Horvath et al., J.Chem.Eng. Japan 16(6) 470 (1983)). The constants required for the implementation of this formula were determined from a measured isotherm of ALPO-5 and its known pore size.

10 This method is particularly useful for microporous materials having pores of up to about 6.0 nm in diameter.

As is indicated in Figure 16, the pore size of the material of Example 4 is 3.96 nm with the peak

15 occurring at $\log(P/P_0) = -0.4$ or $P/P_0 = 0.4$, while the pore size of the material from U.S. Patent 4,880,611 is 1.2 nm or $P/P_0 = 0.02$. In the other materials, a peak is observed at $P/P_0 = 0.015$ which is denoted by an asterisk in Figure 16. This peak reflects adsorption

20 on the walls of the pores and is not otherwise indicative of the size of the pores of a given material. A value of P/P_0 of 0.03 corresponds to 1.3 nm pore size.

The results of this procedure for the samples from

25 Examples 1 through 16 are tabulated below. The samples from Examples 9, 12 and 15 gave two separate peaks, believed to be the result of two separate ultra-large pore phases in the products.

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	<u>Examples</u>	<u>Pore Diameter, nm</u>
	1	3.22
	2	3.54
	3	4.25
5	4	3.96
	5	1.69
	6	2.73
	7	4.26
	8	2.83
10	9	2.28, 3.08
	10	3.68
	11	3.61
	12	3.50, 4.21
	13	4.0
15	14	0.83
	15	2.24, 3.04
	16	1.50

EXAMPLE 21(b)Argon Physisorption For Pore Systems

20

Over About 6.0 nm Diameter

In the pore regime above 6.0 nm diameter, the Kelvin equation can be applied. It is usually given as:

25

$$\ln(P/P_0) = \frac{-2V}{r_k RT} \cos \theta$$

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where:

- = surface tension of sorbate
- V = molar volume of sorbate
- θ = contact angle (usually taken for practical reasons to be 0)
- R = gas constant
- T = absolute temperature
- r_k = capillary condensate (pore) radius
- P/P_0 = relative pressure (taken from the physisorption isotherm)

The Kelvin equation treats adsorption in pore systems as a capillary condensation phenomenon and relates the pressure at which adsorption takes place to the pore diameter through the surface tension and contact angle of the adsorbate (in this case, argon). The principles upon which the Kelvin equation are based are valid for pores in the size range 5 to 100 nm diameter. Below this range the equation no longer reflects physical reality, since true capillary condensation cannot occur in smaller pores; above this range the logarithmic nature of the equation precludes obtaining sufficient accuracy for pore size determination.

The particular implementation of the Kelvin equation often chosen for measurement of pore size is that reported by Dollimore and Heal (D. Dollimore and G.R. Heal, J. Applied Chem., 14, 108 (1964)). This method corrects for the effects of the surface layer of adsorbate on the pore wall, of which the Kelvin equation proper does not take account, and thus provides a more accurate measurement of pore diameter. While the method of Dollimore and Heal was derived for use on desorption isotherms, it can be applied equally well to adsorption isotherms by simply inverting the data set.

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The products of Examples 18 and 19 were subjected to the Dollimore and Heal Method for argon physisorption data, as indicated.

EXAMPLE 22

5

Transmission Electron Microscopy

To further illustrate the nature of the hexagonal crystalline product of this invention, samples of the products from Examples 1-13, 15-19, 23-31 and 36-38 were studied by transmission electron microscopy (TEM) as noted above. TEM is a technique used to reveal the microscopic structure of materials, including crystalline materials.

In order to illuminate the microstructure of materials, samples must be thin enough for an electron beam to pass through them, generally about 50-100 nm thick. The crystal morphology of the present materials usually required that they be prepared for study by ultramicrotomy. While time consuming, this technique of sample preparation is quite familiar to those skilled in the art of electron microscopy. The materials are embedded in a resin, in this case a commercially available low viscosity acrylic resin L.R. WHITE (hard), which is then cured at about 80°C for about 1 1/2 hours. Thin sections of the block are cut on an ultramicrotome using a diamond knife and sections in the thickness range 50-100 nm are collected on fine mesh electron microscope support grids. For these materials, an LKB model microtome with a 45°C diamond knife edge was used; the support grids were 400 mesh copper grids. After evaporation of a thin carbon coating on the sample to prevent charging in the microscope (light gray color on a white sheet of paper next to the sample in the evaporator), the samples are ready for examination in the TEM.

35

A simpler specimen preparation technique can be used with most synthesis preparations if mere verification of the presence of the material of the

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invention is desired. This involves deposition of a dispersion of the material on a carbon-coated lacy Formvar electron microscope support after grinding and sonication in propanol. Fragments or regions sufficiently thin to obtain electron diffraction patterns and lattice images can normally be found near the edges of the crystals. Specimens for analysis of the products of Examples 23-31 and 36-38 were prepared by this dispersion technique.

High resolution TEM micrographs show projections of structure along the direction that the sample is viewed. For this reason, it is necessary to have a sample in specific orientations to see certain details of the microstructure of the material. For crystalline materials, these orientations are most easily chosen by observing the electron diffraction pattern (EDP) that is produced simultaneously with the electron microscope image. Such EDP's are readily produced on modern TEM instruments using, e.g. the selected area field limiting aperture technique familiar to those skilled in the art of electron microscopy. When an EDP with the desired arrangement of diffraction spots is observed, the corresponding image of the crystal giving that EDP will reveal details of the microstructure along the direction of projection indicated by the EDP. In this way, different projections of a crystal's structure can be observed and identified using TEM.

In order to observe the salient features of the crystalline product of the present invention, it is necessary to view the material in an orientation wherein the corresponding EDP gives a hexagonal arrangement of diffraction spots from a single individual crystal. If multiple crystals are present within the field limiting aperture, overlapping diffraction patterns will occur that can be quite difficult to interpret. An example of a hexagonal pattern from an individual crystal from the product in

Example 4 is shown in Figure 17. The number of diffraction spots observed depends to a degree upon the regularity of the crystalline arrangement in the material, among other things. At the very least, however, the inner ring of bright spots should be observed to obtain a good image. Individual crystals can be manipulated by specimen tilt adjustments on the TEM until this orientation is achieved. More often, it is easier to take advantage of the fact that the specimen contains many randomly oriented crystals and to simply search through the sample until a crystal giving the desired EDP (and hence orientation) is located. This latter technique was used to produce the electron micrographs discussed below.

Microtomed samples of materials from the Examples 1-13 and 15-19 were examined by the techniques described above in a JEOL 200 CX transmission electron microscope operated at 200,000 volts with an effective 0.2 nm objective aperture in place. The instrument has a point-to-point resolution of 0.45 nm. Other experimental arrangements familiar to one skilled in the art of high resolution (phase contrast) TEM could be used to produce equivalent images provided care is taken to keep the objective lens on the underfocus side of the minimum contrast lens current setting. Figure 18 is an electron micrograph from a microtomed thin section of the crystalline product from Example 4. This micrograph shows a reasonably regular array of large channels in a hexagonal arrangement. The repeat distance between the channels is about 4.5 nm units, which is consistent with the position of the first peak in the X-ray diffraction pattern ($4.1 \text{ nm}/\sqrt{3}/2$) of this material. Since the channels must have walls between them, this observation is also consistent with the estimated pore size of about 3.96 nm calculated from Argon physisorption measurements of this material in Example 16.

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Figure 19 is an electron micrograph from a microtomed thin section of the crystalline product from Example 5. This micrograph shows a reasonably regular array of somewhat smaller channels in a hexagonal arrangement. The repeat distance between the channels is about 3.0 nm, which is consistent with the position of the first peak in the X-ray diffraction pattern ($2.5 \text{ nm} / \sqrt{3/2}$) of this material. The smaller pore size of this material was also verified by Argon physisorption measurements reported in Example 21(a), where a value of 1.69 nm was calculated for the material in Example 5.

Figure 20 is an electron micrograph from a microtomed thin section of the crystalline product from Example 18. The channels in this image are quite large and rather irregular, but the characteristic hexagonal arrangement of the material of the present invention is evident.

EXAMPLE 23

1.65 grams of NaAlO_2 was added to 80 grams of cetyltrimethylammonium hydroxide (CTMAOH) solution, prepared by contacting a 29 wt.% N,N,N-trimethyl-1-hexadecanaminium chloride solution with a hydroxide-for-halide exchange resin. The mixture was stirred until the NaAlO_2 was completely dissolved. To this solution was added 40.0 grams of tetramethylammonium silicate solution (10 wt.% SiO_2) and 10.0 grams of HiSil (90 wt.% SiO_2). The resulting mixture was stirred at room temperature for several minutes. The gel was then loaded into a 300 ml autoclave and heated to 105°C while stirring at 150 RPM. After about 4 hours of heating, the reaction was quenched with cold water, and the contents removed. The product was filtered and washed several times with warm ($60\text{--}70^\circ\text{C}$) distilled water and with acetone. The final product was calcined to 538°C in a N_2 /air mixture for 8 hours.

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The gel reaction mixture had a composition in terms of moles per mole Al_2O_3 as follows:

1.25 moles Na_2O
27.8 moles SiO_2
5.1 moles $(\text{CTMA})_2\text{O}$
2.24 moles $(\text{TMA})_2\text{O}$
650 moles H_2O

The calcined product of this example proved to have a surface area of $1187 \text{ m}^2/\text{g}$ and a benzene adsorption capacity of 66 grams/100 grams.

The X-ray diffraction pattern of the calcined product of this example is shown in Figure 21, from which it will be seen that the product included a very strong relative intensity line at $3.68 \pm 0.2 \text{ nm}$ d-spacing, and weak lines at 2.12 ± 0.1 and $1.83 \pm 0.1 \text{ nm}$. The product of this example was examined by transmission electron microscopy (TEM), which produced images of a hexagonal arrangement of uniform pores and hexagonal electron diffraction pattern with a d_{100} value of about 3.8 nm.

EXAMPLES 24-31

Eight separate experiments were conducted following the procedure of Example 23, but with an auxiliary organic added to the initial reaction mixture. In each case the auxiliary organic was 1,3,5-trimethylbenzene (TMB) added to the reaction mixture as the last ingredient. The concentration of TMB was varied between the experiments, as shown in Table A. Also shown in Table A are the product pore sizes, pore volumes in cc/g and equilibrium benzene sorption values. The pore size and pore volume values for Examples 24, 27 and 30 were extrapolated from plots of d-spacings versus measured pore sizes and pore volumes for the other examples (see Figures 23 and 24). The strongest X-ray diffraction lines are also

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indicated for comparison purposes. Figure 22 plots the effect of TMB auxiliary organic on the d-spacing of the first X-ray diffraction pattern maxima in terms of moles of TMB/mole SiO_2 in the respective reaction mixture. As the concentration of the auxiliary organic is increased in the reaction mixture, pore size and volume increase for the product crystalline material.

TEM examination of the calcined product of each of Examples 24-31 produced an image of a hexagonal arrangement of uniform pores and a hexagonal electron diffraction pattern with a d_{100} value corresponding to the d-spacing of a peak in the X-ray diffraction pattern.

TABLE A

EXAMPLE	MOLES TMB	TMB/SiO ₂ (MOLAR)	TMB/CTMA+ (MOLAR)	D-SPACING (NM)	PORE SIZE (NM)	BENZENE SORPTION (g/100g AT 6.7KPA)
23	0	0	0	3.68	3.2, 3.77	66
24	0.025	0.12	0.32	4.03	4.15	61
25	0.050	0.23	0.65	4.53	4.51	62
26	0.075	0.35	0.97	4.81	5.25	48
27	0.100	0.46	1.30	5.48	5.80	37
28	0.150	0.70	1.95	6.22	6.30	43
29	0.150	0.70	1.95	6.22	6.90	36
30	0.183	0.85	2.38	6.37	6.81	32
31	0.216	1.00	2.80	6.51	7.02	38

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EXAMPLES 32-45

To exemplify which organic compounds provide suitable auxiliary organic materials for use in the present invention, Example 23 was repeated but in each case 10 grams of a potential auxiliary organic was added directly to the reaction mixture before the addition of the HiSil. The results are shown in Table B, from which it will be seen that n-octadecane (Example 40), 1-pentanol (Example 43) and phenol (Example 44) failed to result in significant change in the d-spacing of the strongest X-ray diffraction line or gave an amorphous product. All the remaining materials listed in Table B provided significant change in the position of the strongest X-ray line and hence are suitable auxiliary organics.

TEM examination of the calcined product of each of Examples 36-38 produced an image of a hexagonal arrangement of uniform pores and a hexagonal electron diffraction pattern with a d_{100} value generally corresponding to the d-spacing of a peak in the X-ray diffraction pattern.

TABLE B

EXAMPLE	AUXILIARY ORGANIC	MOLES AUX. ORG.	AUX/S102 (MOLAR)	D-SPACING (NM)	BENZENE SORPTION (g/100g AT 6.7KPA)
23	NONE	0	0	3.68	66
32	P-XYLENE	0.094	0.44	4.98	39
33	1,3,5-TRIMETHYLBENZENE	0.083	0.39	5.12	38
34	1,3,5-TRIETHYLBENZENE	0.062	0.29	4.81	36
35	1,3,5-TRIISOPROPYLBENZENE	0.049	0.23	4.49	43
36	1,3-DIMETHYLBADAMANTANE	0.061	0.28	4.89	42
37	N-PENTANE	0.139	0.64	4.72	31
38	N-DECANE	0.070	0.33	4.64	48
39	N-DODECANE	0.059	0.27	4.28	48
40	N-OCTADECANE	0.039	0.18	3.70	54
41	1-PHENYLNONANE	0.049	0.23	4.64	34
42	1,8-DIBROMOCTANE	0.037	0.17	4.49	33
43	1-PENTANOL	0.113	0.53	AMORPHOUS	28
44	PHENOL	0.106	0.49	AMORPHOUS	N/A
45	PYRIDINE	0.126	0.59	4.64	N/A

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EXAMPLE 46

A solution was prepared by dissolving 1.08 grams of cobalt nitrate hexahydrate in 10 grams of water. Into this solution was stirred 40 grams of 29 wt% CTMA hydroxide aqueous solution, 10 grams of a tetrabutylammonium (TBA) silicate solution (prepared by combining 168 grams of tetraethylorthosilicate with 270 grams of 55 wt% TBA hydroxide aqueous solution) and 5 grams of HiSil silica. The resultant mixture had the following composition in terms of moles per mole of silica:

0.21 moles $(\text{CTMA})_2\text{O}$
0.07 moles $(\text{TBA})_2\text{O}$
0.04 moles CoO
25.7 moles H_2O .

The mixture was placed in a polypropylene bottle and put in a steam box for 72 hours. The resultant solid product was filtered, washed, air-dried and then calcined for 10 hours in air at 540°C . The calcined product had an equilibrium benzene sorption capacity of 40 wt% and an X-ray diffraction pattern as shown in Figure 25. It will be seen that the pattern included a very strong line at a d-spacing of 3.7 ± 0.2 nm and weak lines at d-spacings of 2.1 ± 0.1 and 1.9 ± 0.1 nm.

EXAMPLE 47

The procedure of Example 46 was repeated but with the cobalt compound replaced with 1.08 grams of nickel nitrate hexahydrate. The resultant calcined product had an equilibrium benzene sorption capacity of 60 wt% and the X-ray diffraction pattern shown in Figure 26 (with a very strong line at a d-spacing of 3.7 ± 0.2 nm and a weak line at a d-spacing of 2.1 ± 0.1 nm).

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EXAMPLE 48

A solution was prepared by dissolving 4.5 grams of chromium sulfate hydrate in 20 grams of water. Into this solution was stirred 200 grams of 29 wt% CTMA hydroxide aqueous solution, 50 grams of a tetrabutylammonium (TBA) silicate solution (prepared by combining 168 grams of tetraethylorthosilicate with 270 grams of 55 wt% TBA hydroxide aqueous solution) and 25 grams of HiSil silica. The resultant mixture had the following composition in terms of moles per mole of silica:

0.21 moles $(\text{CTMA})_2\text{O}$
0.07 moles $(\text{TBA})_2\text{O}$
0.02 moles Cr_2O_3
22.0 moles H_2O .

The mixture was placed in a polypropylene bottle and put in a steam box for 72 hours. The resultant solid product was filtered, washed, air-dried and then calcined for 10 hours in air at 540°C. The calcined product had an equilibrium benzene sorption capacity of 40 wt% and an X-ray diffraction pattern as shown in Figure 27. It will be seen that the pattern included a very strong line at a d-spacing of 3.9 ± 0.2 nm and a weak line at a d-spacing of 2.1 ± 0.1 nm.

EXAMPLE 49

50 grams of cetyltrimethylammonium hydroxide prepared as in Example 1 was combined with 5 grams of tetraethylorthosilicate and 14.5 grams of tetramethylammonium silicate solution (10% silica) with stirring. The stirring was continued for 1 hour and to the resultant solution was added a gallium nitrate solution prepared by dissolving 1.2 grams of $\text{Ga}(\text{NO}_3)_3 \cdot x\text{H}_2\text{O}$ in 10 grams of water. Assuming complete exchange of the surfactant, the mixture had the

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following composition in terms of moles per mole of silica

0.5 moles $(\text{CTMA})_2\text{O}$
0.05 moles Ga_2O_3
66 moles H_2O

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This mixture was placed in a polypropylene bottle and put into a steam box for 48 hours at about 95°C. The resultant product was filtered, washed, air-dried and then calcined (1 hour at 540°C in flowing nitrogen followed by 6 hours in air). The X-ray pattern of the calcined product is shown in Figure 28 and includes a very strong line at a d-spacing of 3.4 ± 0.2 nm and weak lines at d-spacings of 2.1 ± 0.1 and 1.8 ± 0.1 nm. The chemical analysis of the as-synthesized product was as follows:

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40 wt% carbon
2.5 wt% nitrogen
15 wt% silicon
2.8 wt% gallium
0.07 wt% aluminum
39.9 wt% ash (1000°C).

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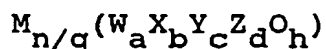
Claims:

1. A composition of matter comprising an inorganic, porous, non-layered crystalline phase material exhibiting, after calcination, an X-ray diffraction pattern with at least one peak at a d-spacing greater than 1.8 nm and having a benzene adsorption capacity of greater than 15 grams benzene per 100 grams of said material at 6.7 kPa (50 torr) and 25°C.
2. A composition of matter comprising an inorganic, porous crystalline phase material having a hexagonal arrangement of uniformly-sized pores at least 1.3 nm in diameter and exhibiting, after calcination, a hexagonal electron diffraction pattern that can be indexed with a d_{100} value greater than 1.8 nm.
3. The composition of claim 2 wherein said crystalline phase material has an X-ray diffraction pattern following calcination with at least one peak whose d-spacing corresponds to the d_{100} value from the electron diffraction pattern.
4. The composition of claim 1 or claim 2 wherein said crystalline phase material has an X-ray diffraction pattern following calcination with at least two peaks at positions greater than 1.0 nm d-spacing, at least one of which is at a position greater than 1.8 nm d-spacing, and no peaks at positions less than about 1.0 nm d-spacing with relative intensity greater than 20% of the strongest peak.
5. The composition of claim 4 wherein said material has no peaks at positions less than about 1.0

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nm d-spacing with relative intensity greater than 10% of the strongest peak.

6. The composition of claim 1 or claim 2 wherein said crystalline phase has a composition expressed as follows:



- 5 wherein M is one or more ions; n is the charge of the composition excluding M expressed as oxides; q is the weighted molar average valence of M; n/q is the number of moles or mole fraction of M; W is one or more divalent elements; X is one or more trivalent elements;
 10 Y is one or more tetravalent elements; Z is one or more pentavalent elements; a, b, c, and d are mole fractions of W, X, Y, and Z, respectively; h is a number of from 1 to 2.5; and $(a+b+c+d) = 1$.

7. The composition of claim 6 wherein the sum $(a+b+c)$ is greater than d, and $h = 2$.

8. The composition of claim 6 wherein W comprises a divalent first row transition metal or magnesium; X comprises aluminum, boron, chromium, gallium or iron; Y comprises silicon or germanium; and
 5 Z comprises phosphorus.

9. The composition of claim 8 wherein W comprises cobalt, X comprises aluminum, Y comprises silicon and Z comprises phosphorus.

10. The composition of claim 6 wherein a and d are 0 and $h = 2$.

11. The composition of claim 10 herein X comprises aluminum and Y comprises silicon.

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12. The composition of matter of claim 1 having an X-ray diffraction pattern substantially as shown in any one of Figures 1 to 14, 21 and 25 to 28.

13. A method for synthesizing the composition of matter of claim 1 or claim 2, which comprises crystallizing a reaction mixture having a composition in terms of mole ratios of oxides, within the following ranges:

	X_2O_3/YO_2	0 to 0.5
	$X_2O_3/(YO_2+Z_2O_5)$	0.1 to 100
	$X_2O_3/(YO_2+WO+Z_2O_5)$	0.1 to 100
	Solvent/ 10 $(YO_2+WO+Z_2O_5+X_2O_3)$	1 to 1500
	OH^-/YO_2	0 to 10
	$(M_{2/e}O+R_{2/f}O)/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.01 to 20
	$M_{2/e}O/$ 15 $(YO_2+WO+Z_2O_5+X_2O_3)$	0 to 10
	$R_{2/f}O/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.01 to 2.0

wherein e and f are the weighted average valences of M and R, respectively, wherein the solvent is a C_1 to C_6 alcohol or diol, or water and wherein R comprises an organic directing agent having the formula $R_1R_2R_3R_4Q^+$, wherein Q is nitrogen or phosphorus and at least one of R_1 , R_2 , R_3 and R_4 is aryl or alkyl group having 6 to 36 carbon atoms and each of the remainder of R_1 , R_2 , R_3 and R_4 is selected from hydrogen and an alkyl group having 1 to 5 carbon atoms.

14. The method of claim 13 wherein the reaction mixture has a composition in terms of mole ratios of oxides, within the following ranges:

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	X_2O_3/YO_2	0.001 to 0.5
5	$X_2O_3/(YO_2+Z_2O_5)$	0.1 to 20
	$X_2O_3/(YO_2+WO+Z_2O_5)$	0.1 to 20
	Solvent/ $(YO_2+WO+Z_2O_5+X_2O_3)$	5 to 1000
	OH^-/YO_2	0 to 5
10	$(M_2/e^O+R_2/f^O)/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.05 to 5
	$M_2/e^O/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0 to 5
15	$R_2/f^O/$ $(YO_2+WO+Z_2O_5+X_2O_3)$	0.03 to 1.0.

15. The method of claim 13 or claim 14 wherein said organic directing agent is selected from cetyltrimethylammonium, cetyltrimethylphosphonium, octadecyltrimethylphosphonium, benzyltrimethylammonium, cetylpyridinium, myristyltrimethylammonium, decyltrimethylammonium, dodecyltrimethylammonium and dimethyldidodecylammonium compounds.

16. The method of claim 13 or claim 14 wherein R comprises an additional organic directing agent having the same formula as the first-mentioned directing agent but wherein each of R_1 , R_2 , R_3 and R_4 is selected from hydrogen and an alkyl group of 1 to 5 carbon atoms.

17. The method of claim 16 wherein the additional organic directing agent is selected from tetramethylammonium, tetraethylammonium, tetrapropylammonium and tetrabutylammonium compounds.

18. The method of claim 13 or claim 14 wherein R comprises an auxiliary organic selected from (1) aromatic hydrocarbons and amines having 5-20 carbon

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atoms and halogen- and C_1-C_{14} alkyl-substituted
5 derivatives thereof (2) cyclic and polycyclic aliphatic
hydrocarbons and amines of 5 to 20 carbon atoms and
halogen- and C_1-C_{14} alkyl-substituted derivatives
thereof and (3) straight and branched chain aliphatic
hydrocarbons and amines having 3-16 carbon atoms and
10 halogen-substituted derivatives thereof.

19. The method of claim 18 wherein the auxiliary
organic is p-xylene, trimethylbenzene, triethylbenzene
or triisopropylbenzene.

20. The method of claim 18 wherein the mole ratio
of auxiliary organic/ YO_2 is 0.05 to 20.

21. The method of claim 18 wherein the mole ratio
of auxiliary organic/organic directing agent(s) is 0.02
to 100.

22. The method of claim 13 wherein the
crystallization is conducted at a temperature of 25 to
250°C for 5 minutes to 14 days.

23. The method of claim 13 wherein the
crystallization is conducted at a temperature of 50 to
175°C and a pH of 9 to 14 for 5 to 300 hours.

24. A process for effecting catalytic conversion
of an organic compound- or inorganic
compound-containing feedstock which comprises
contacting said feedstock under catalytic conversion
5 conditions with a catalyst comprising an active form of
the composition of any one of claims 1 to 12.

25. The process of claim 24 wherein the feedstock
comprises a hydrocarbon and the conversion involves

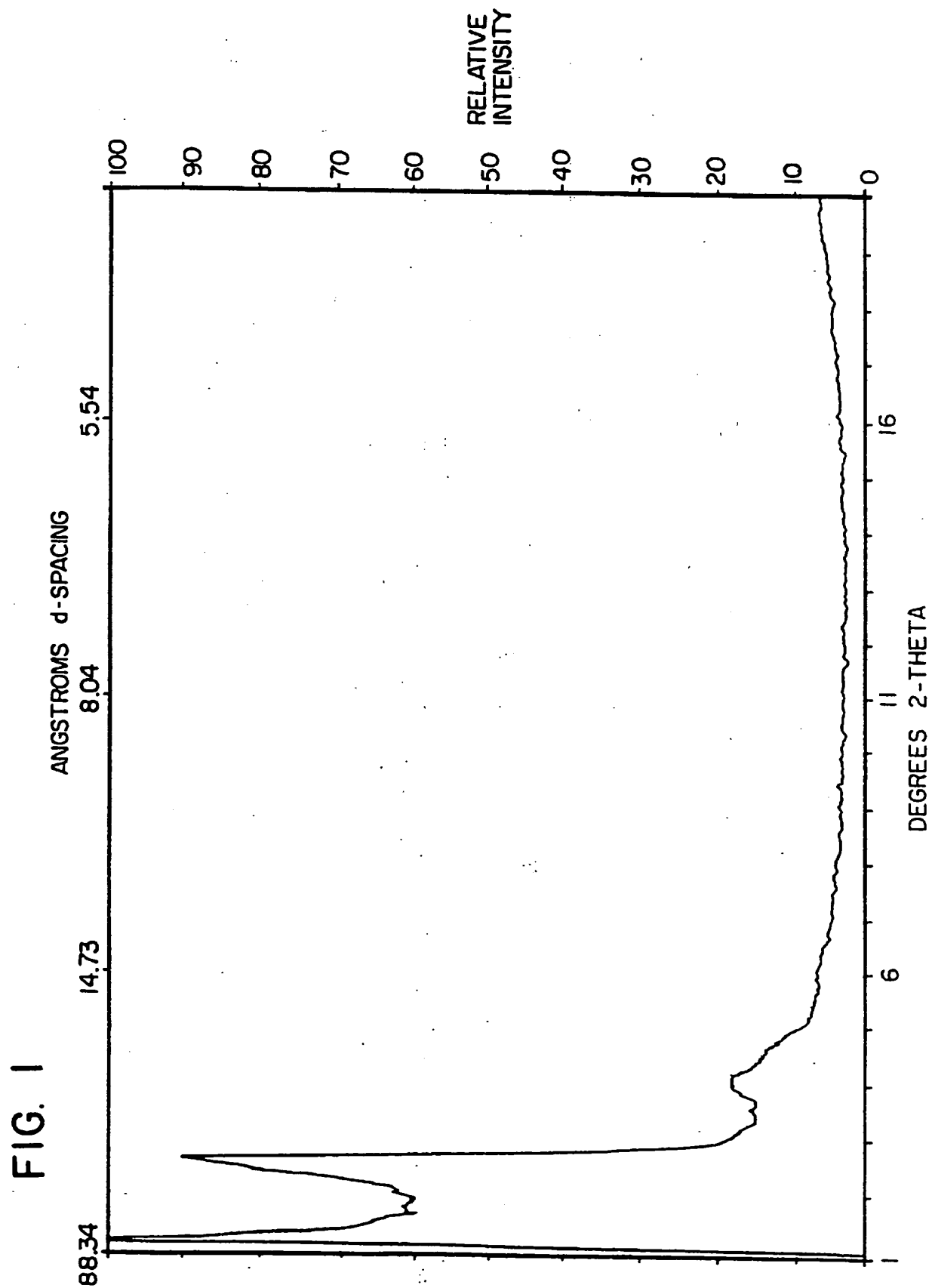
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cracking or hydrocracking to reduce the molecular weight of the hydrocarbon.

26. The process of claim 24 wherein the feedstock comprises an oxide of nitrogen and the conversion involves chemical reduction of said nitrogen oxide.

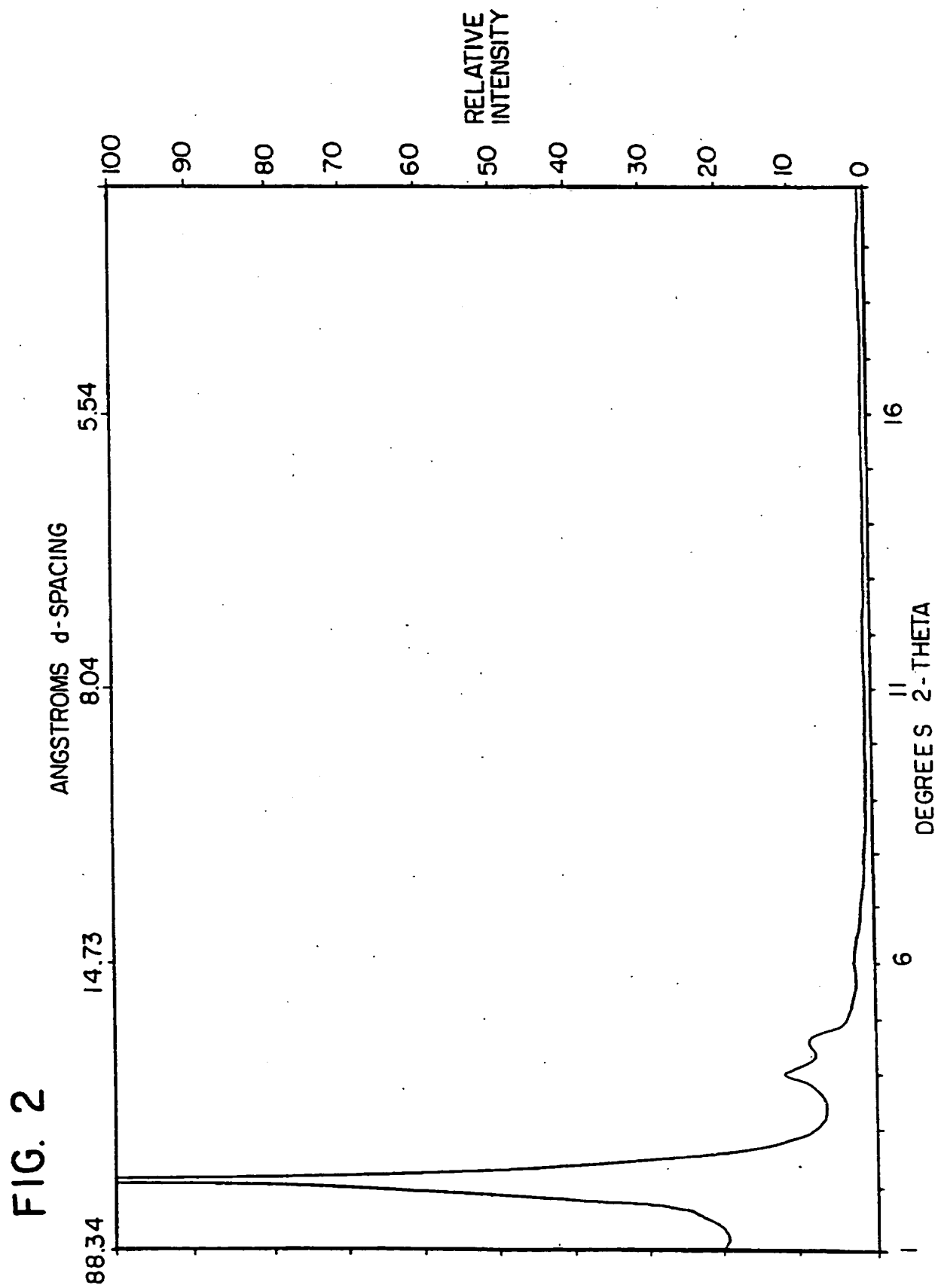
27. Use of the composition of any one of claims 1 to 12 in the selective sorption of one component from a mixture of components.

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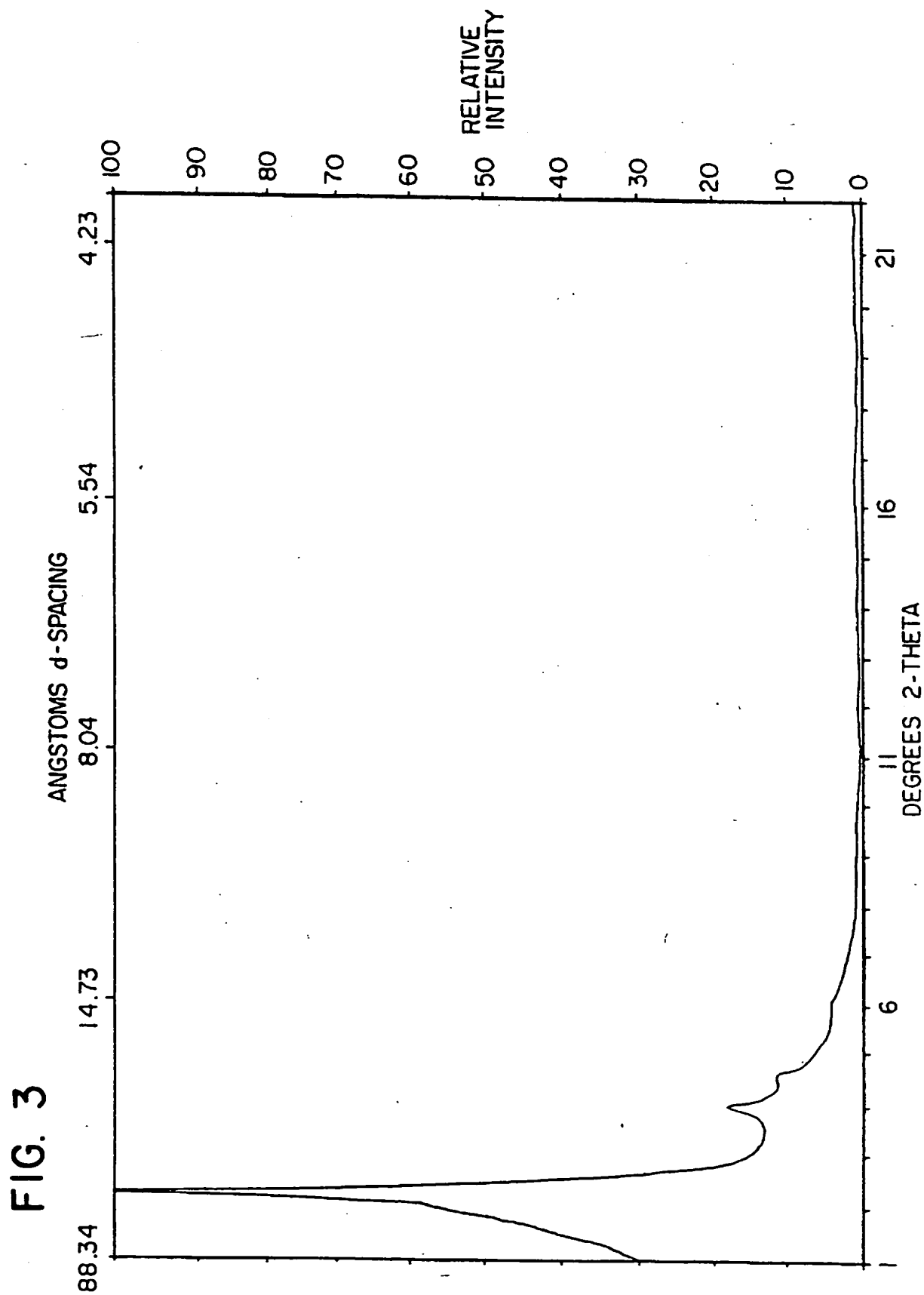
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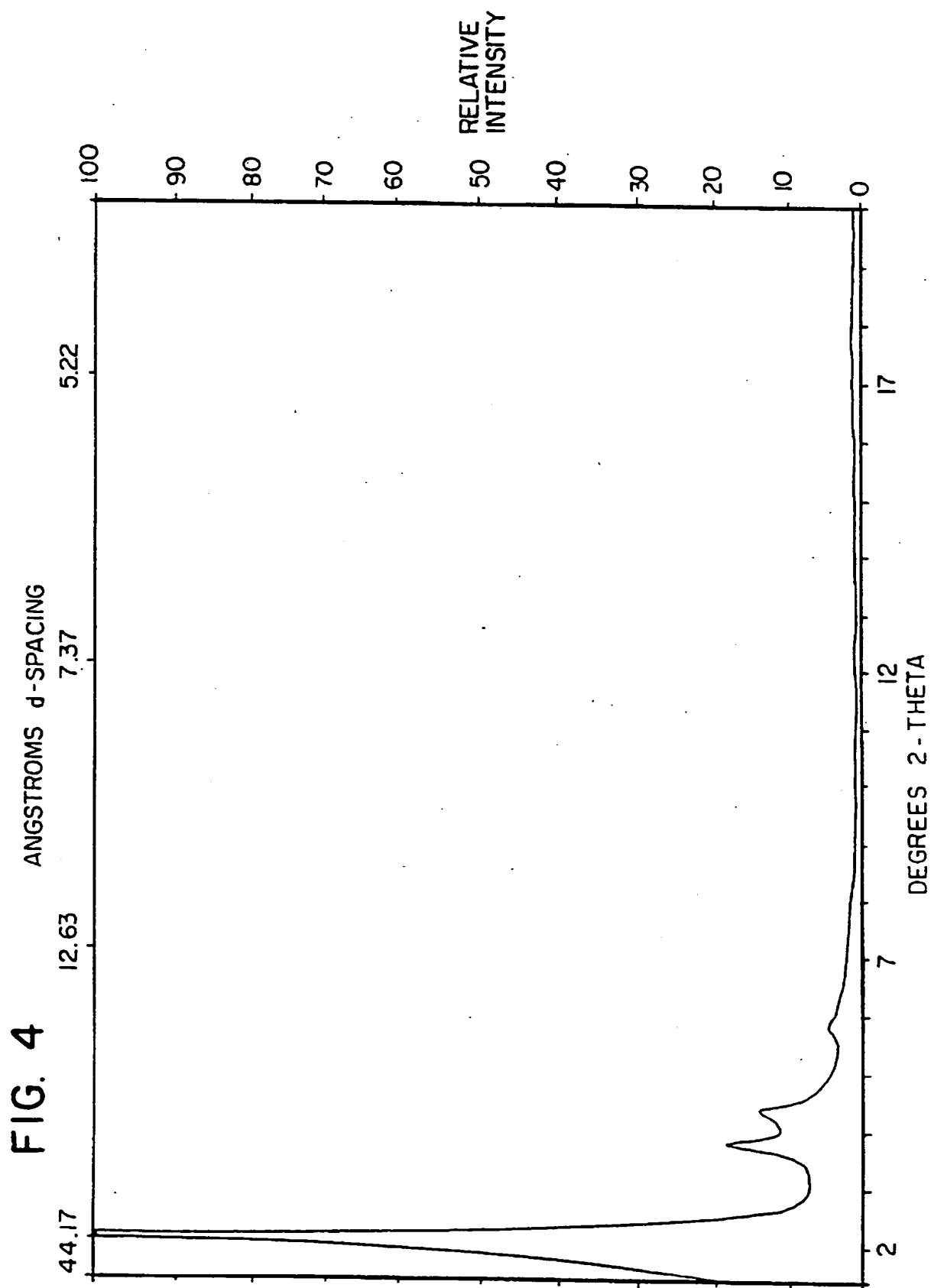
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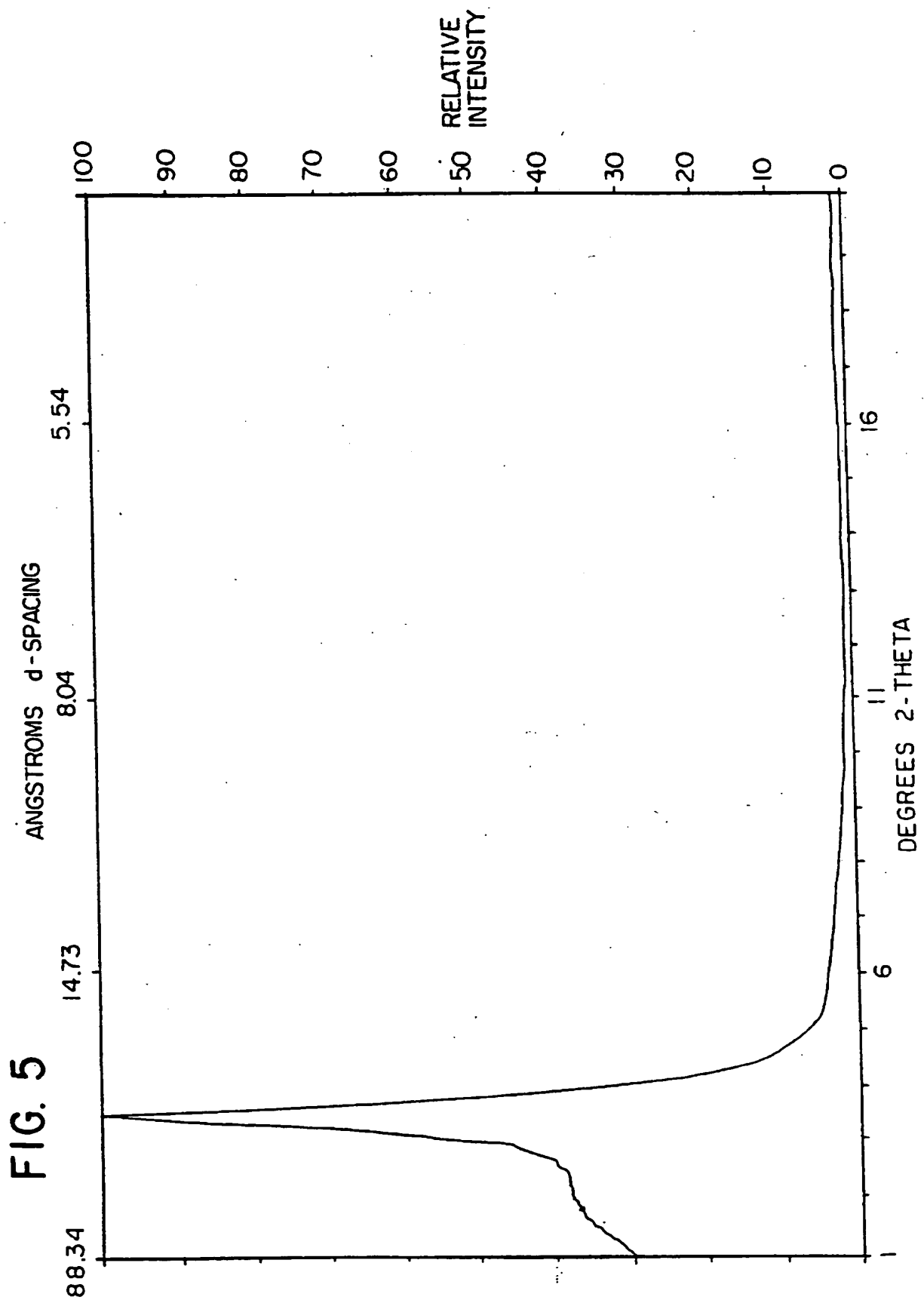
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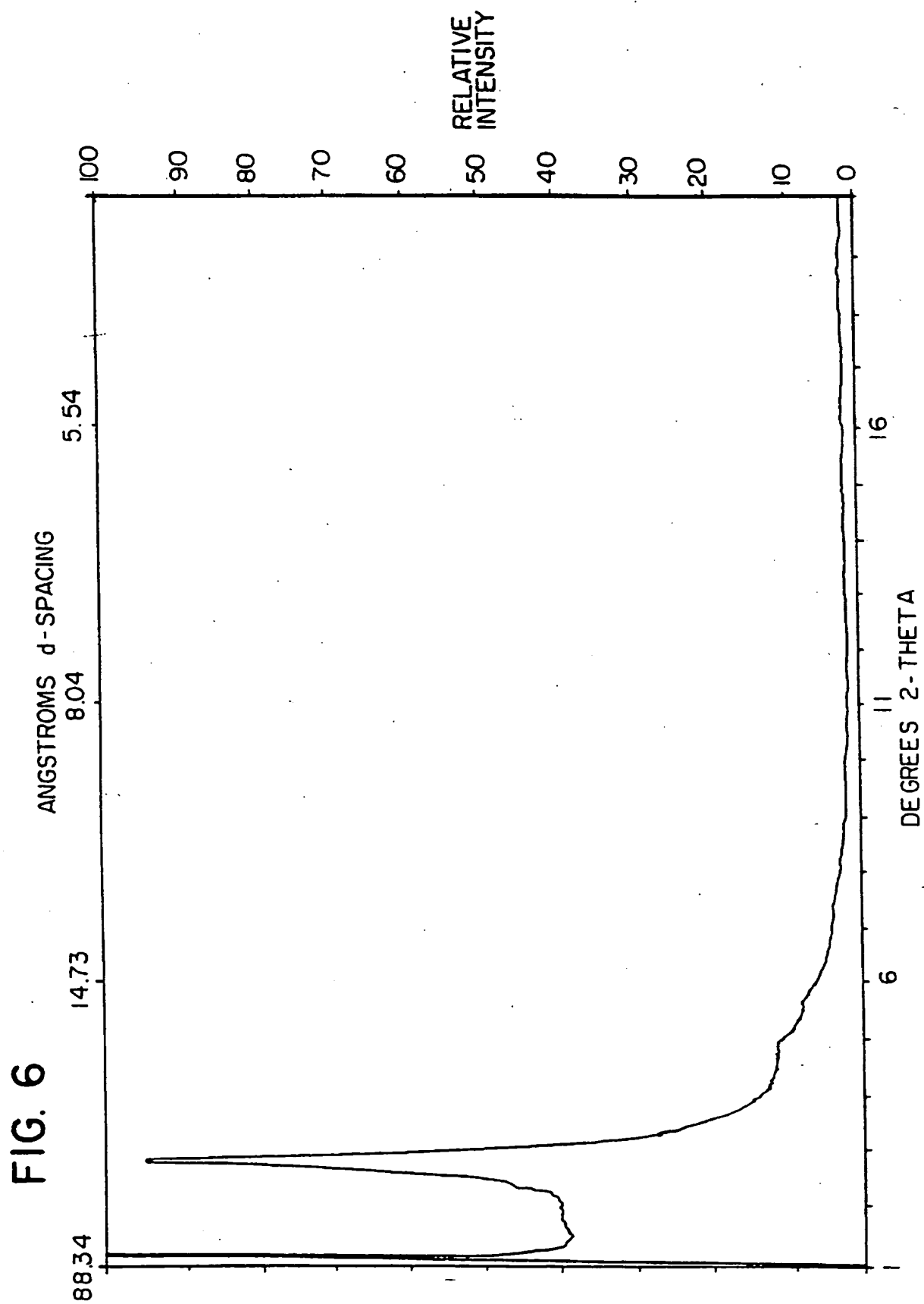
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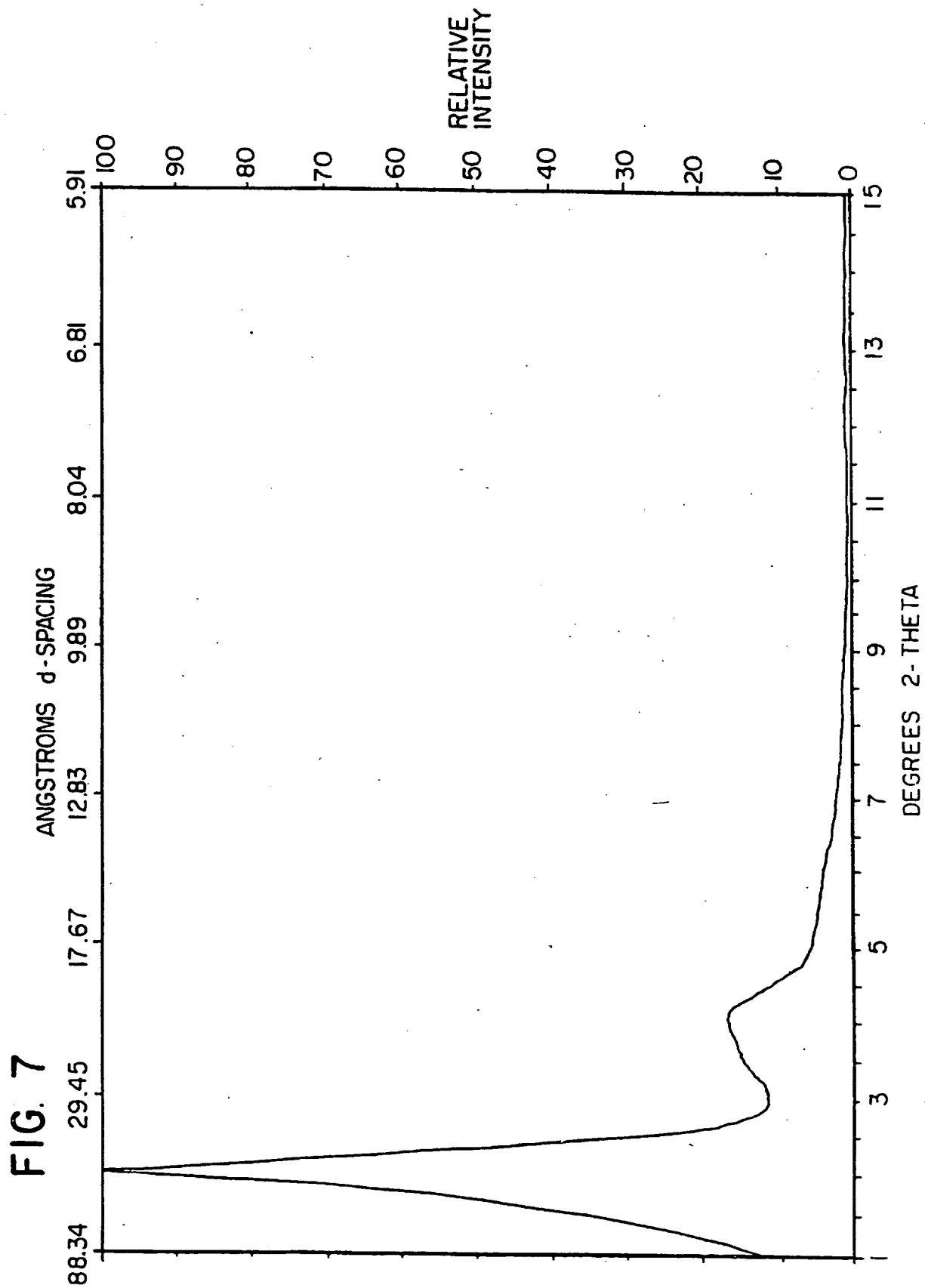
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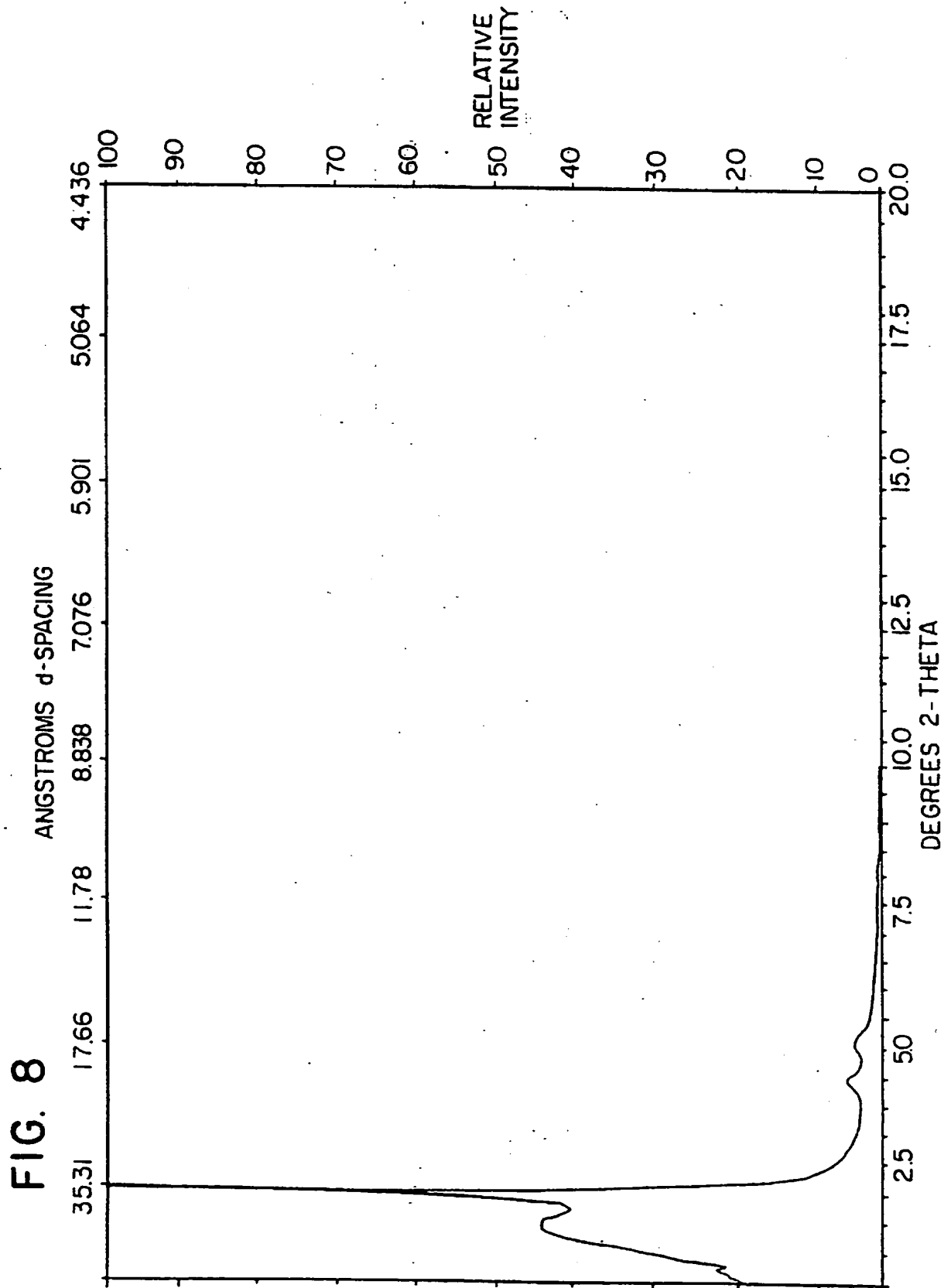
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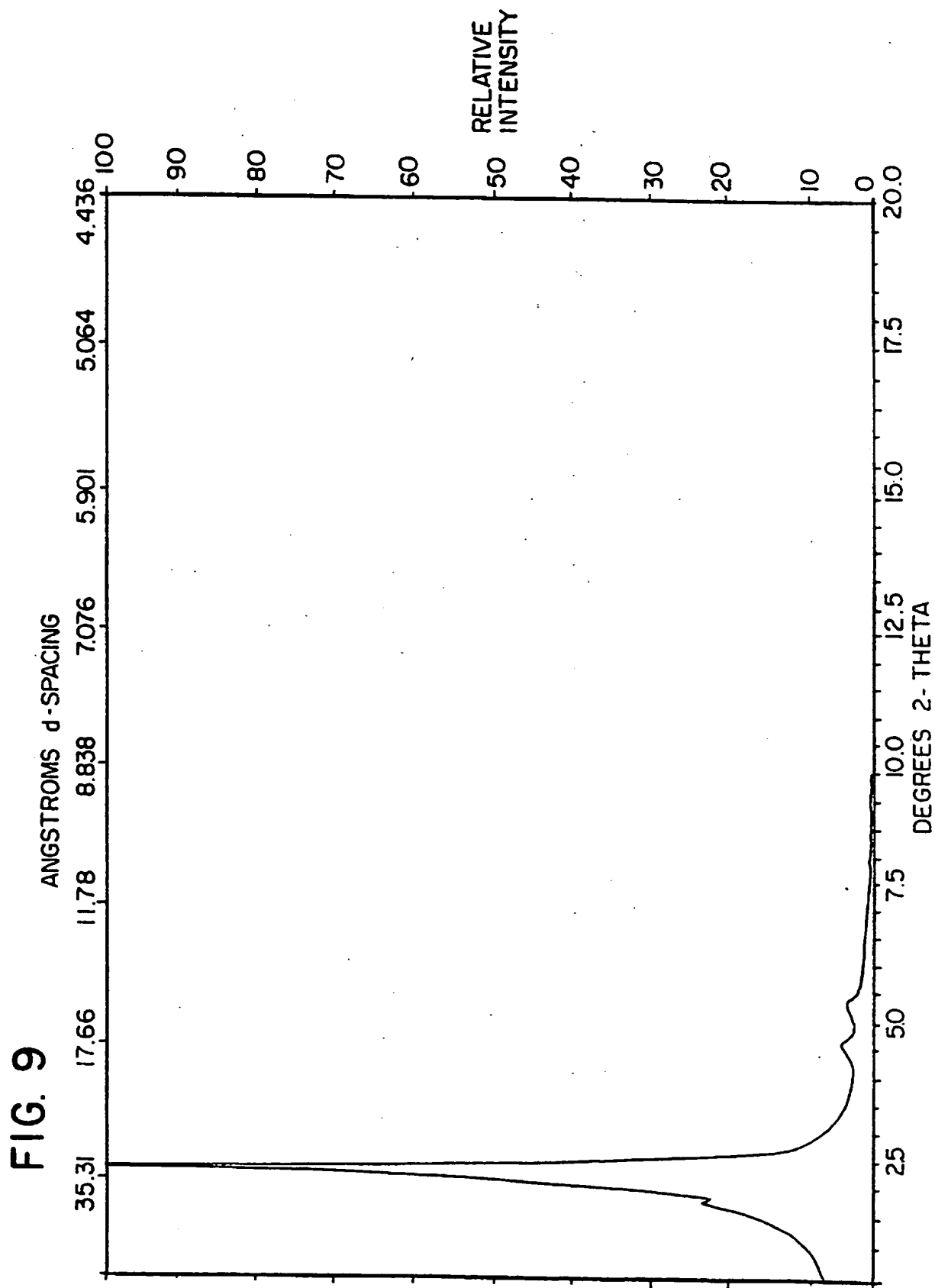
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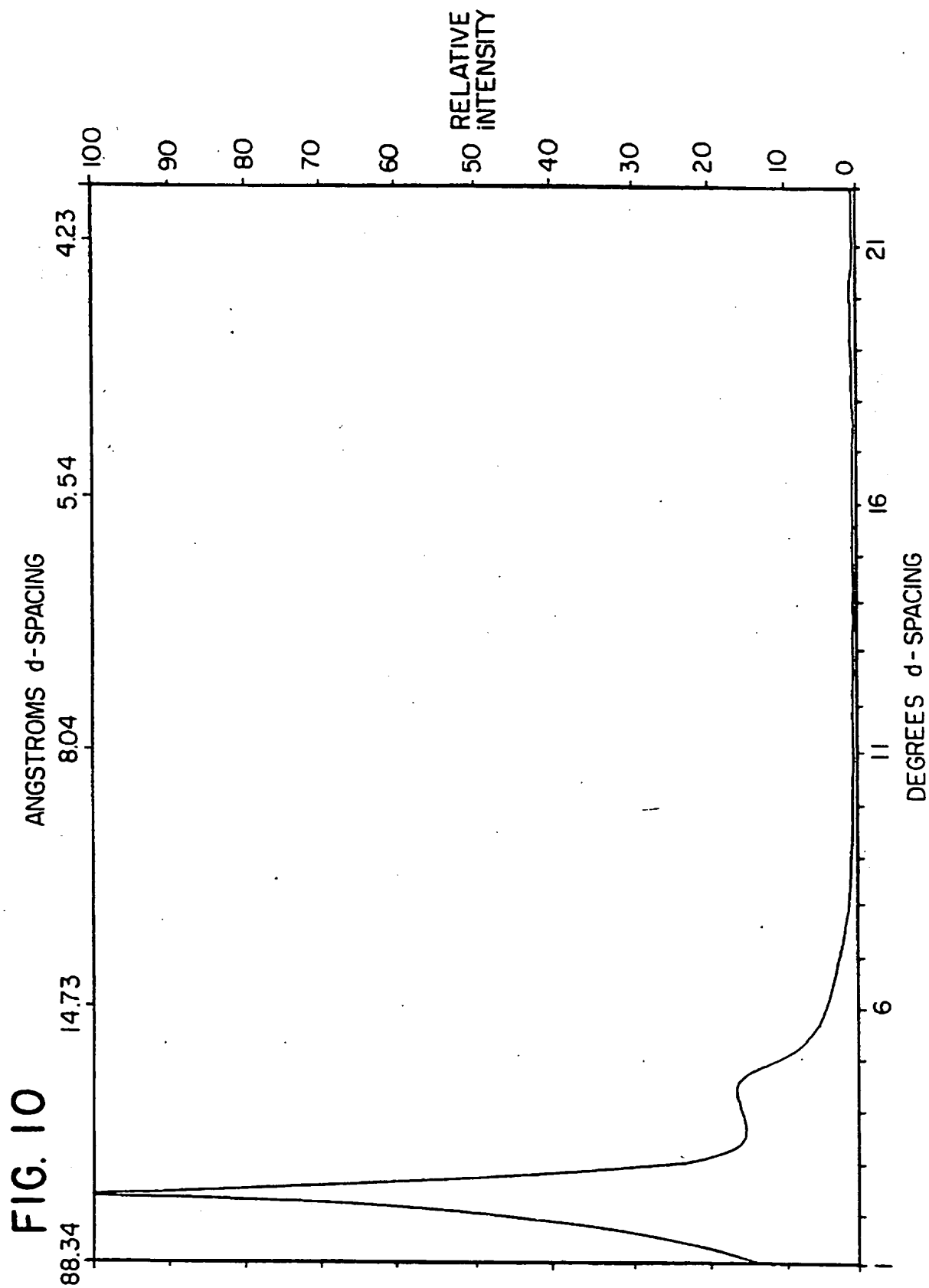
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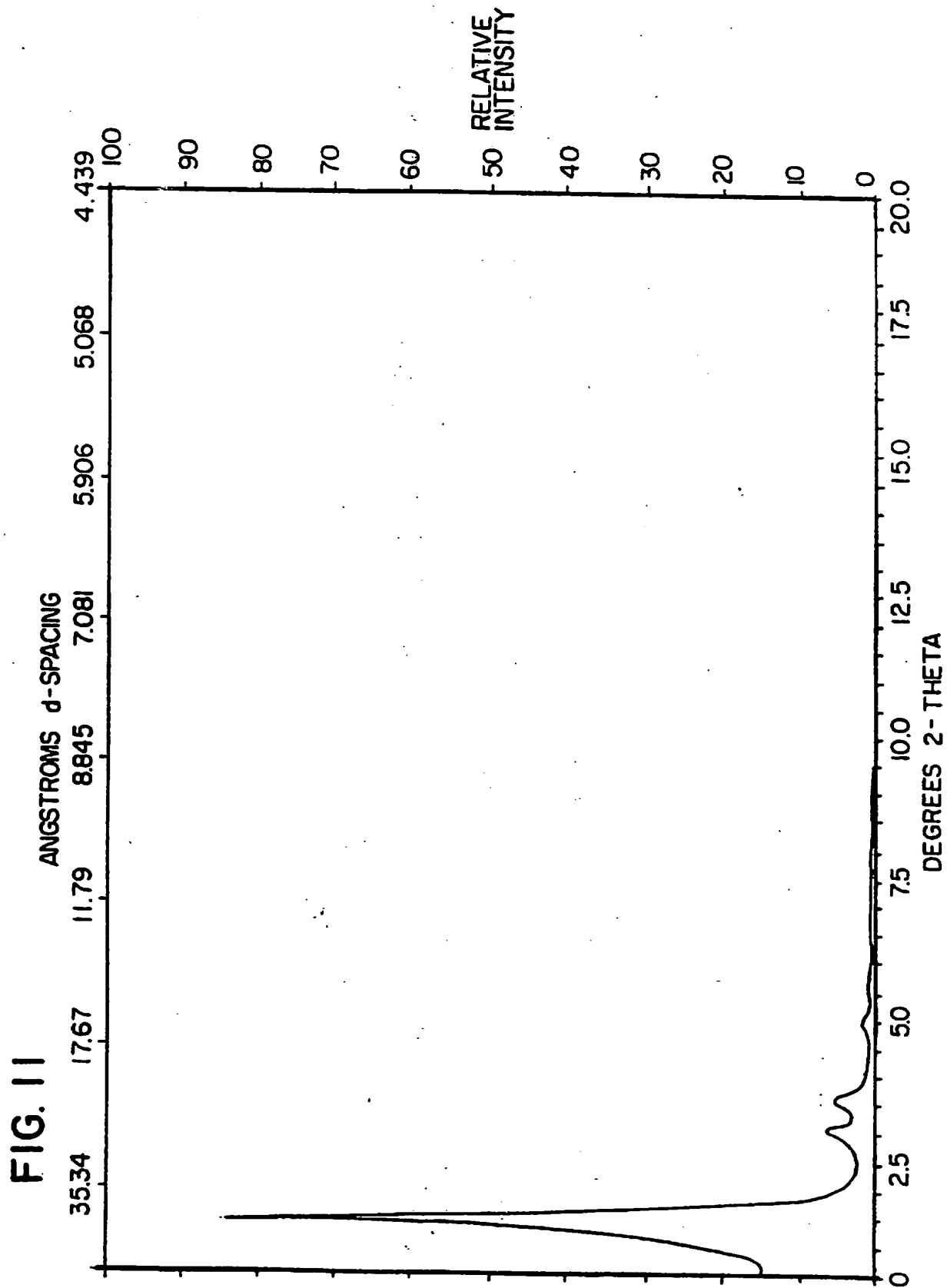
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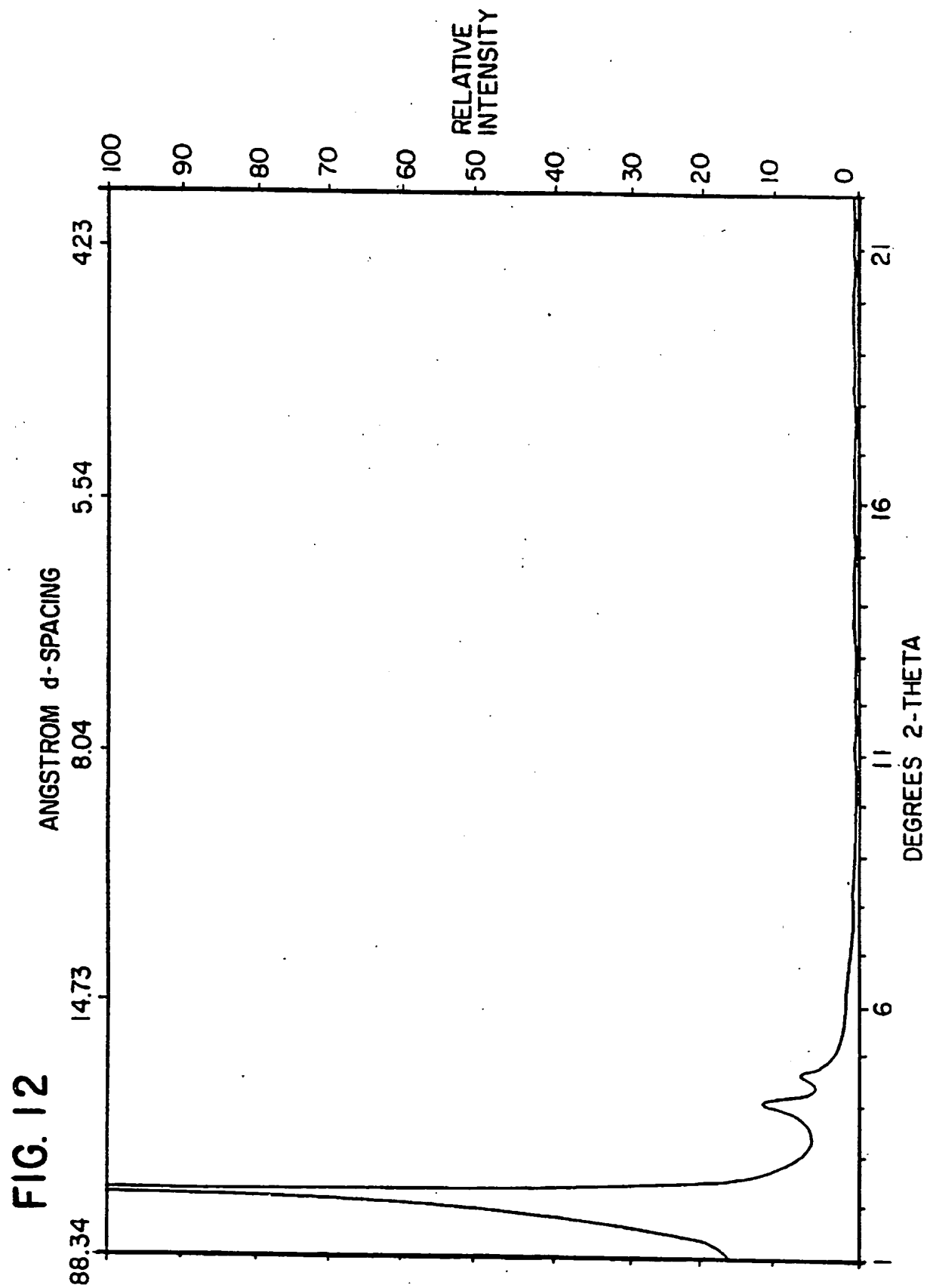
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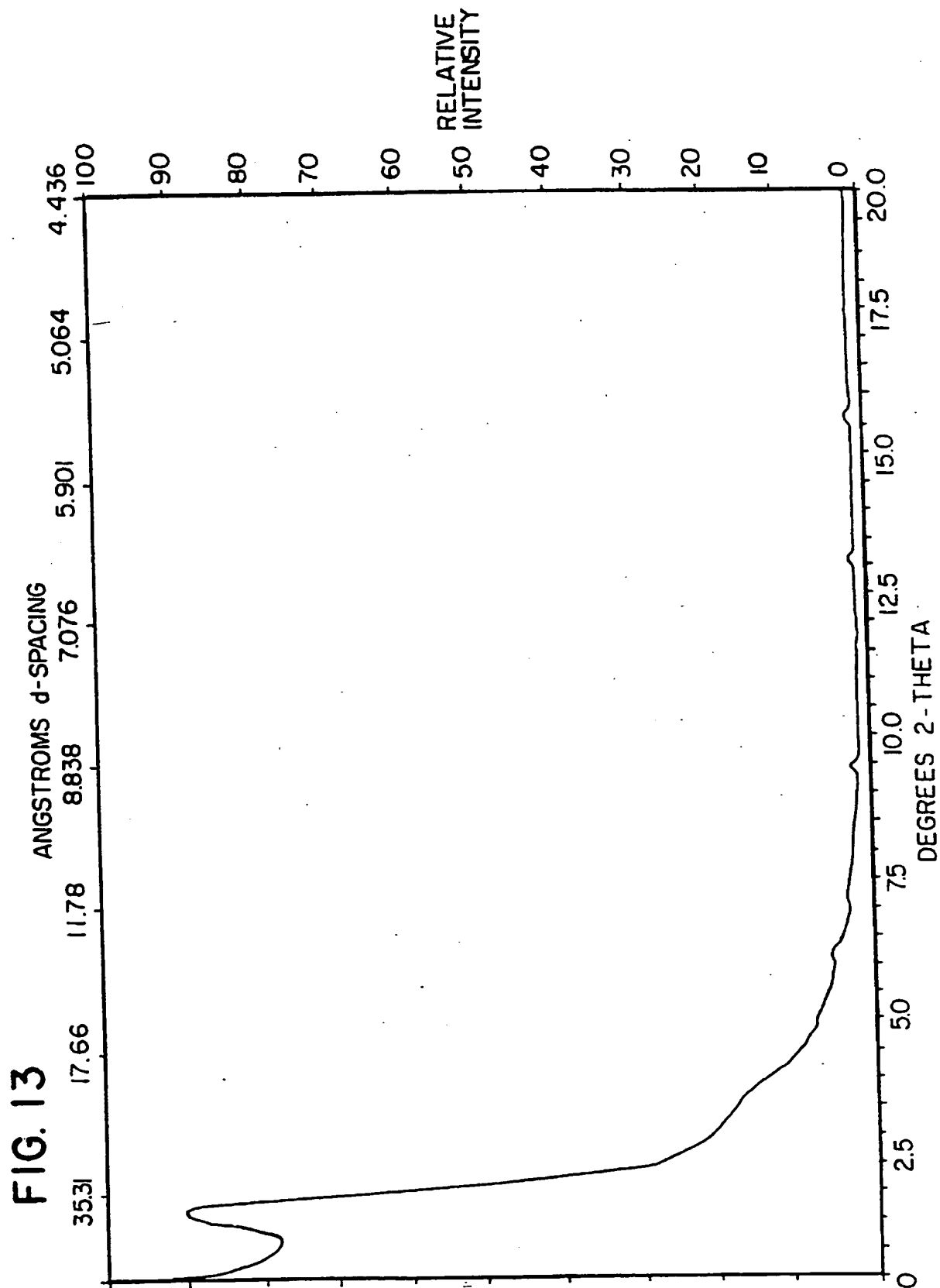
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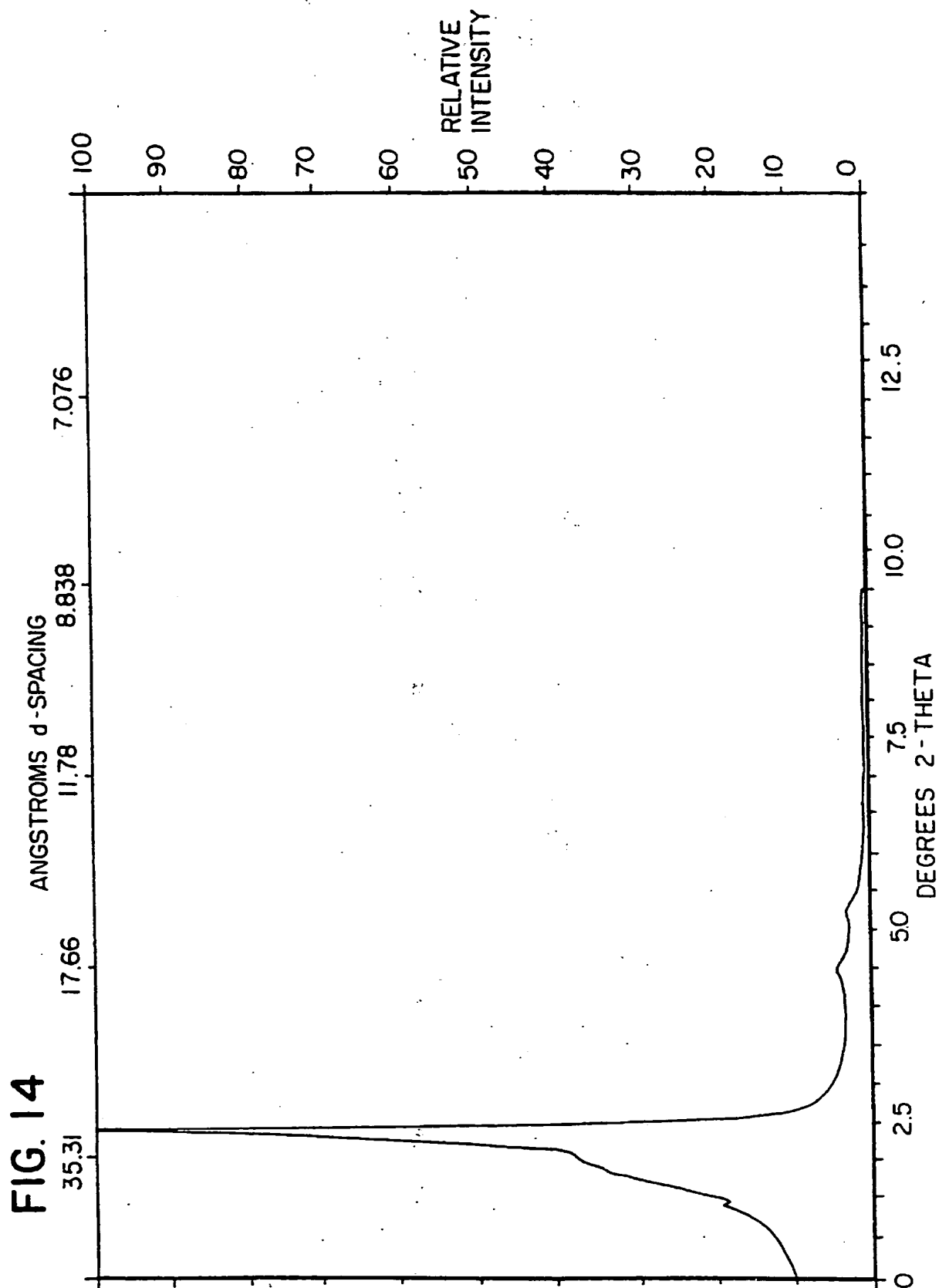
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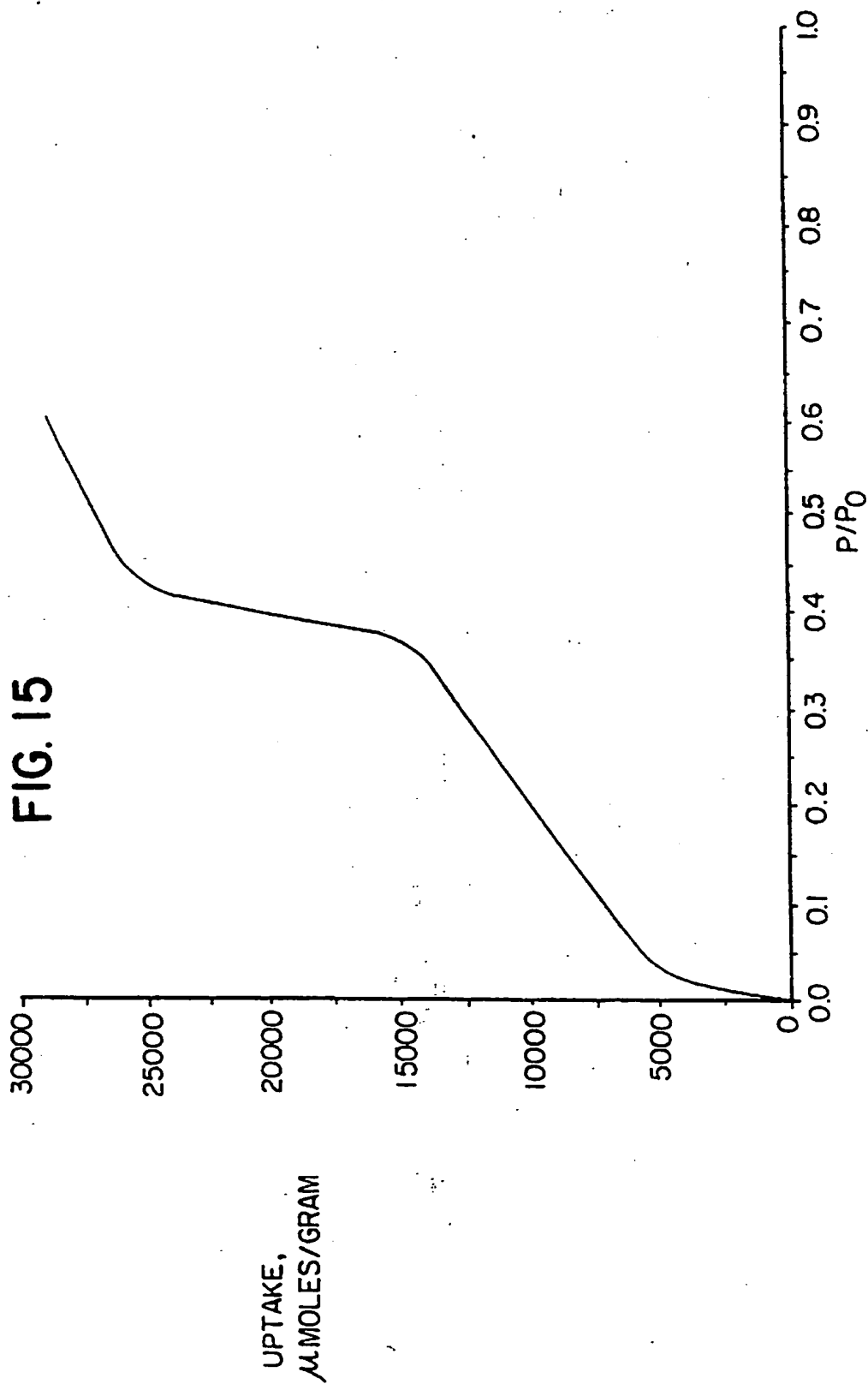
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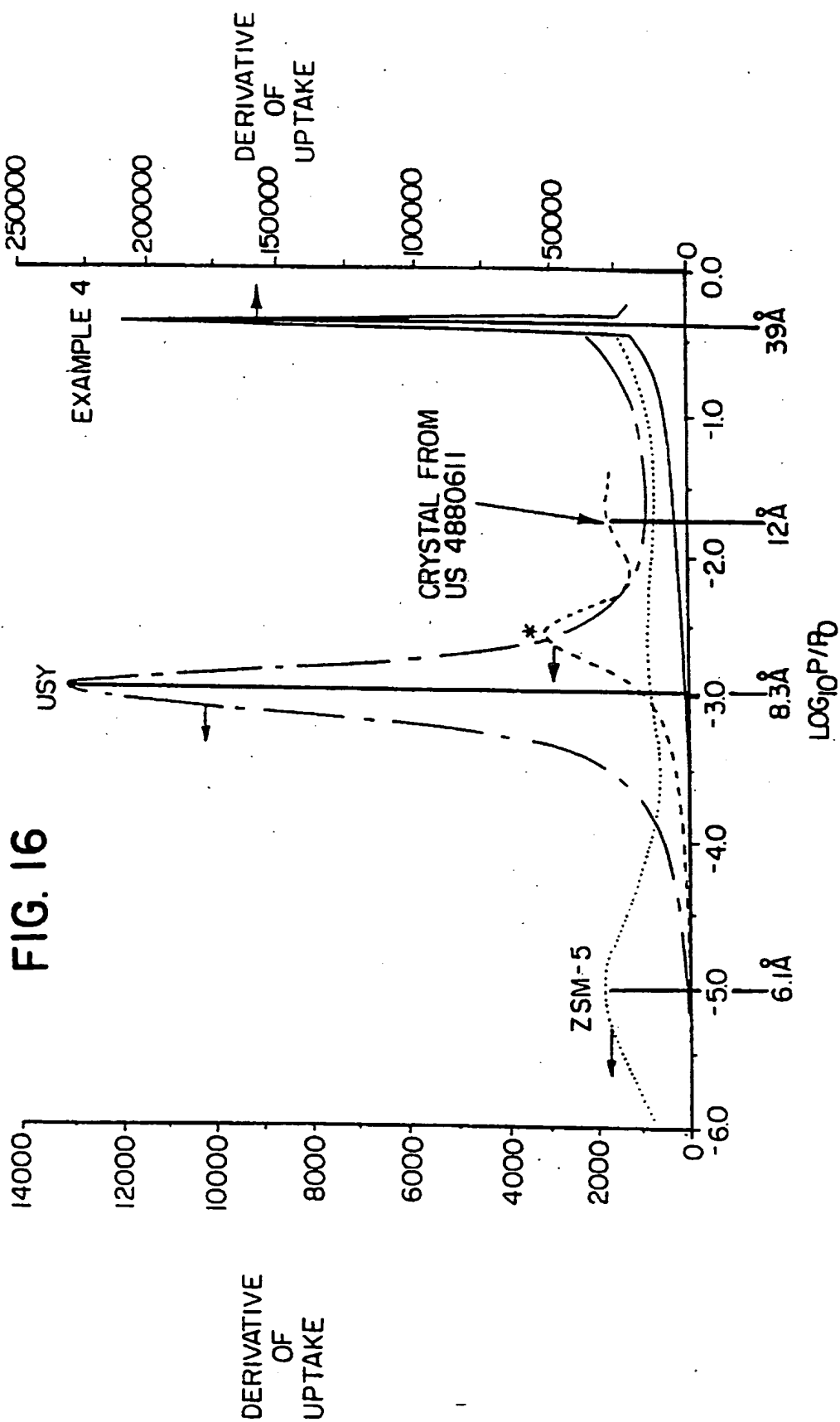


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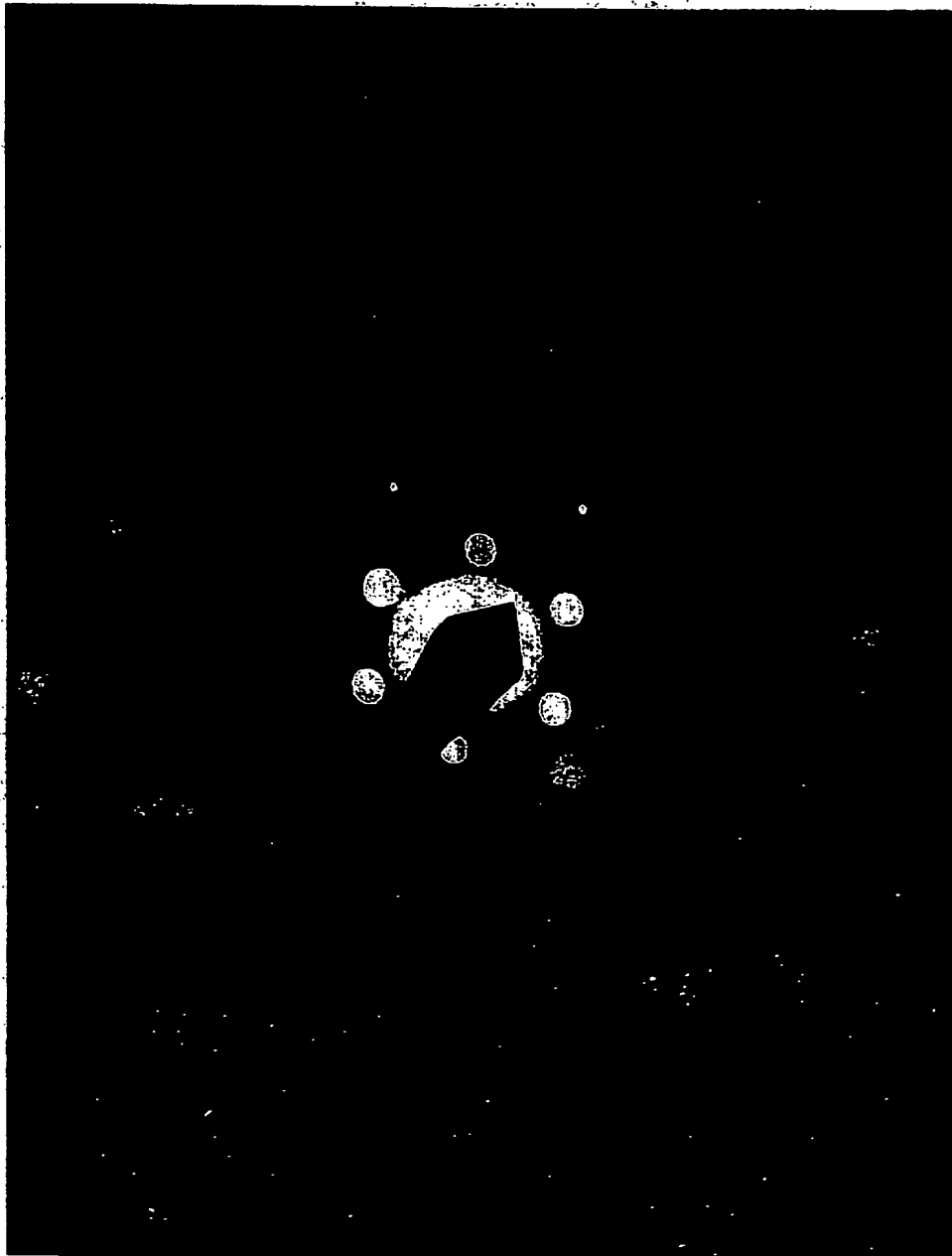


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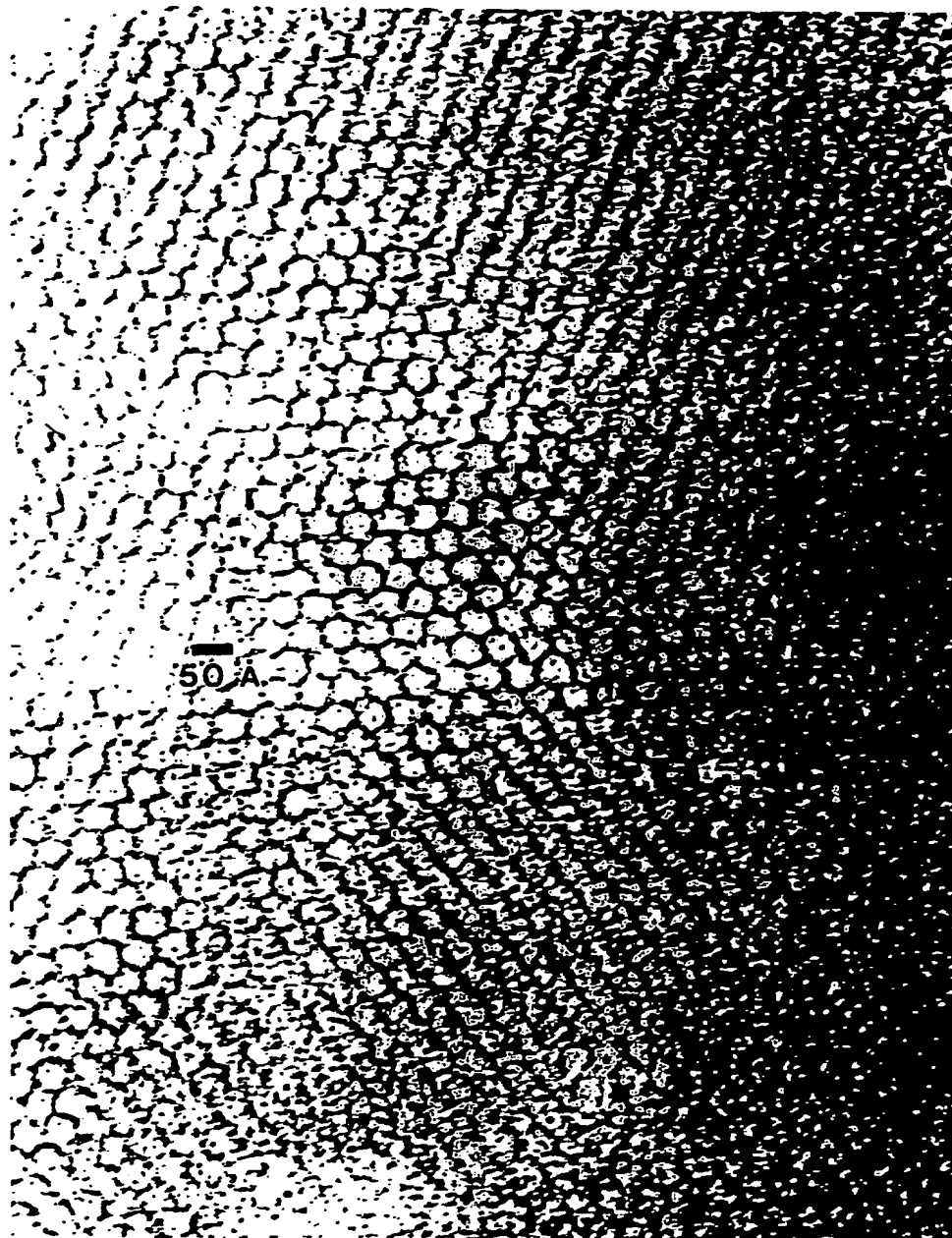
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FIG. 17



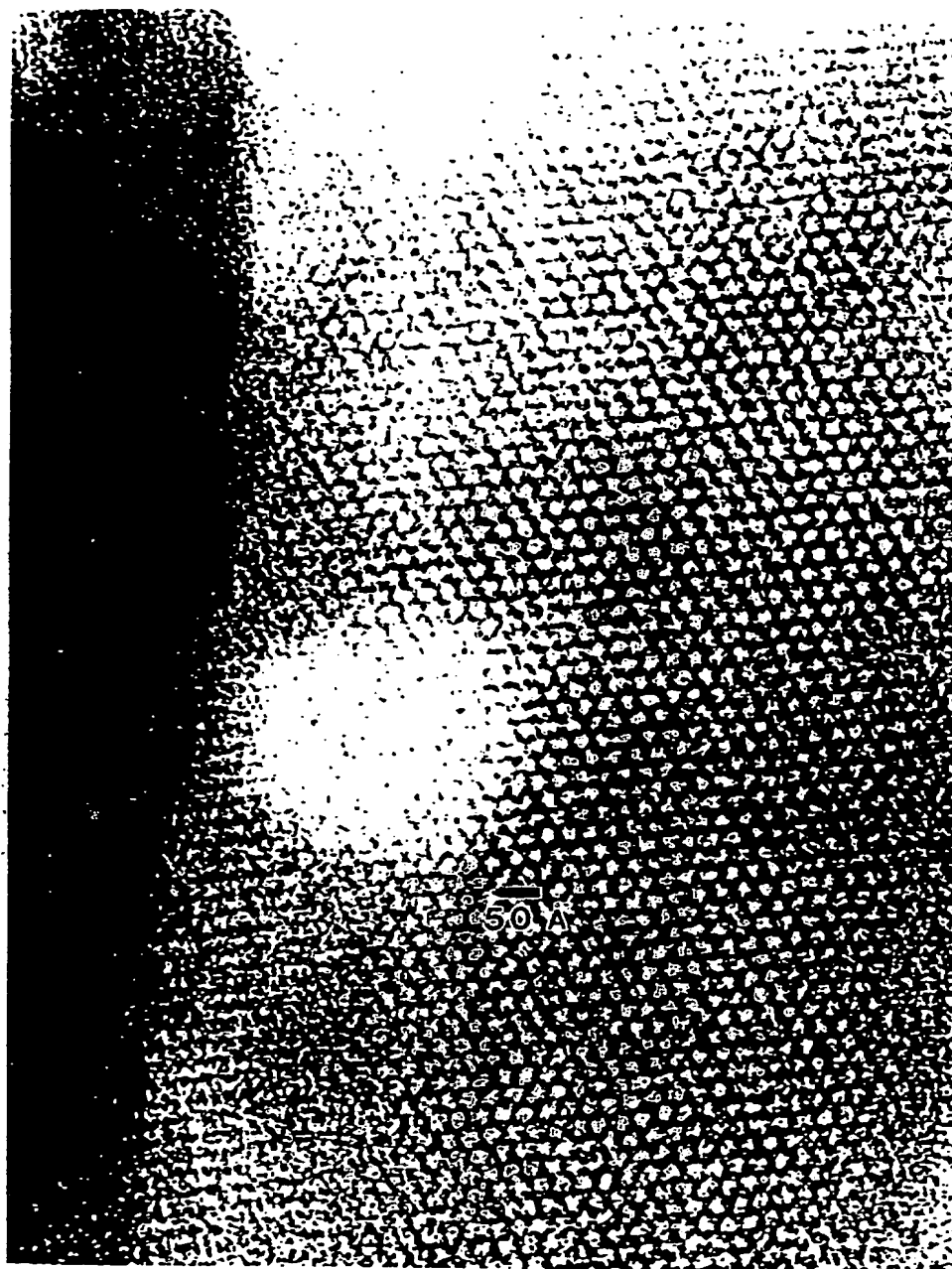
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FIG. 18



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FIG. 19

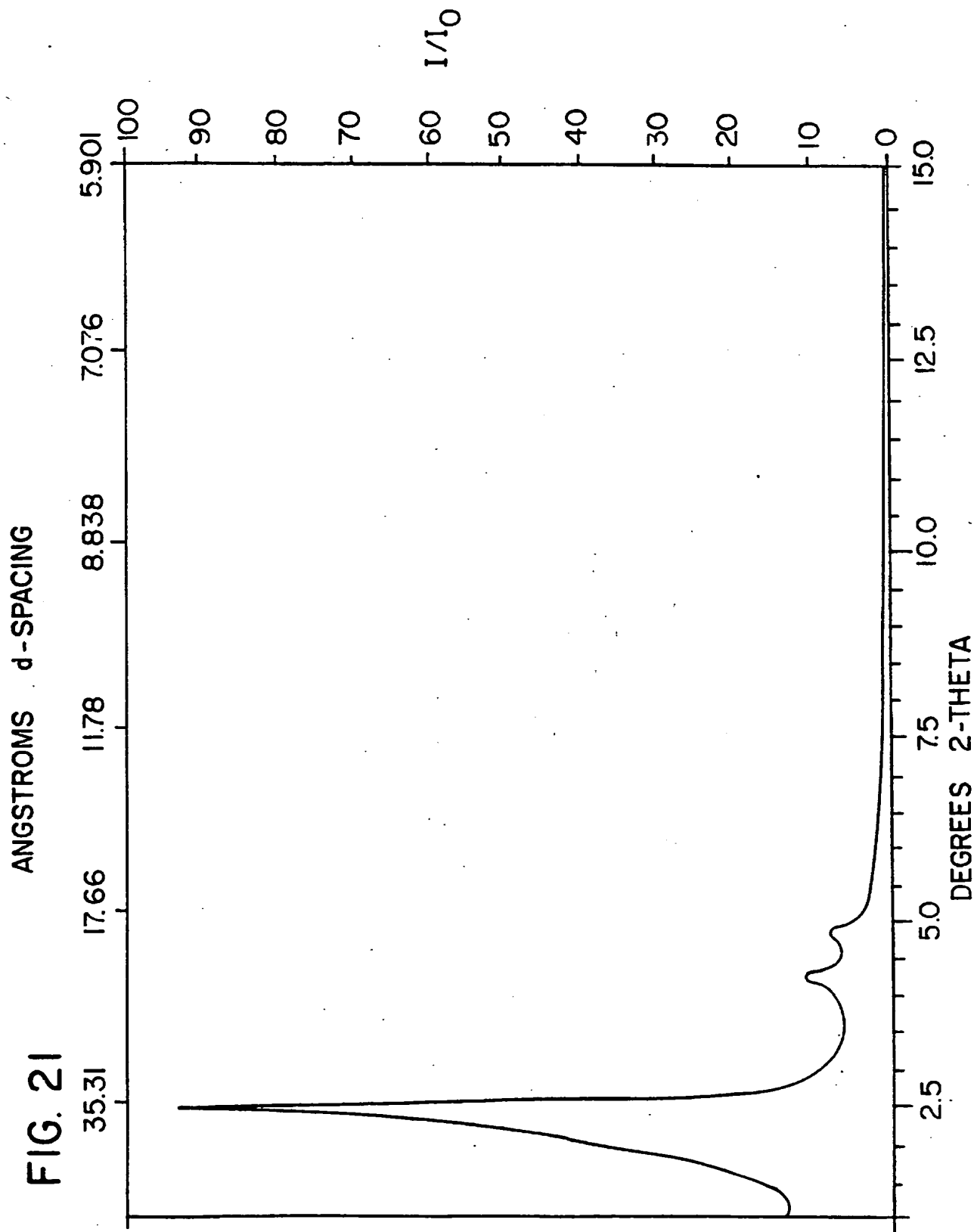


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FIG. 20

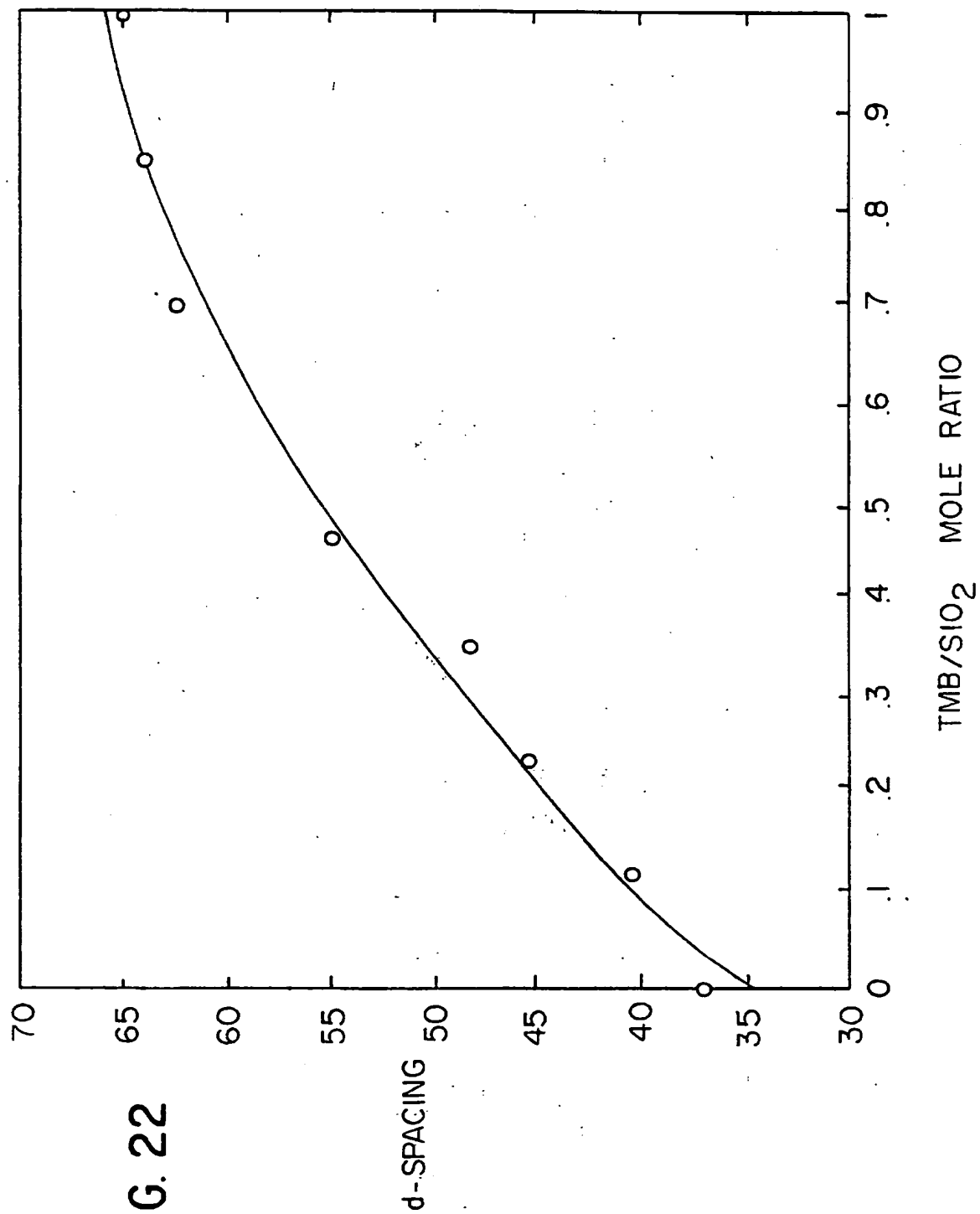


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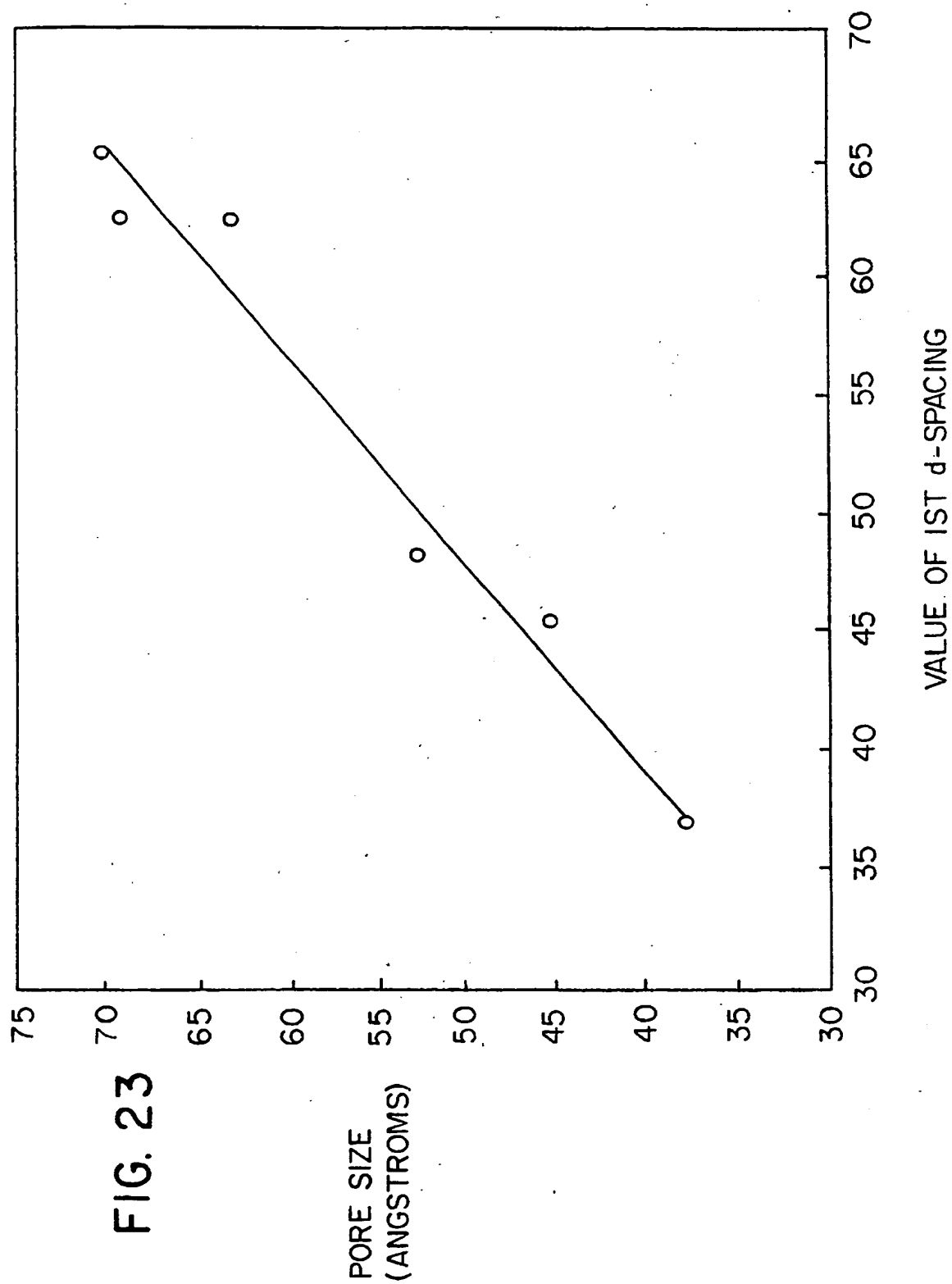


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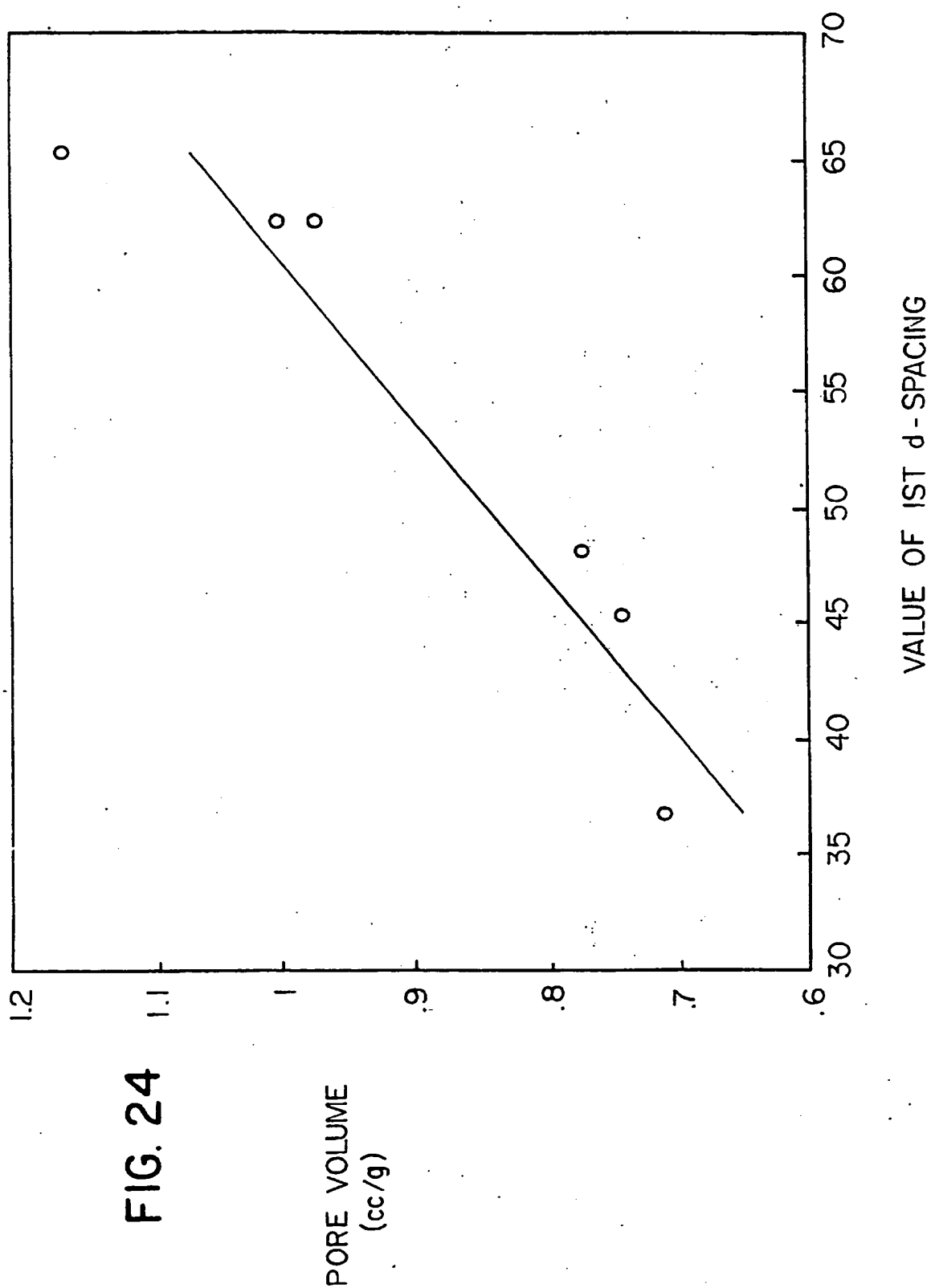
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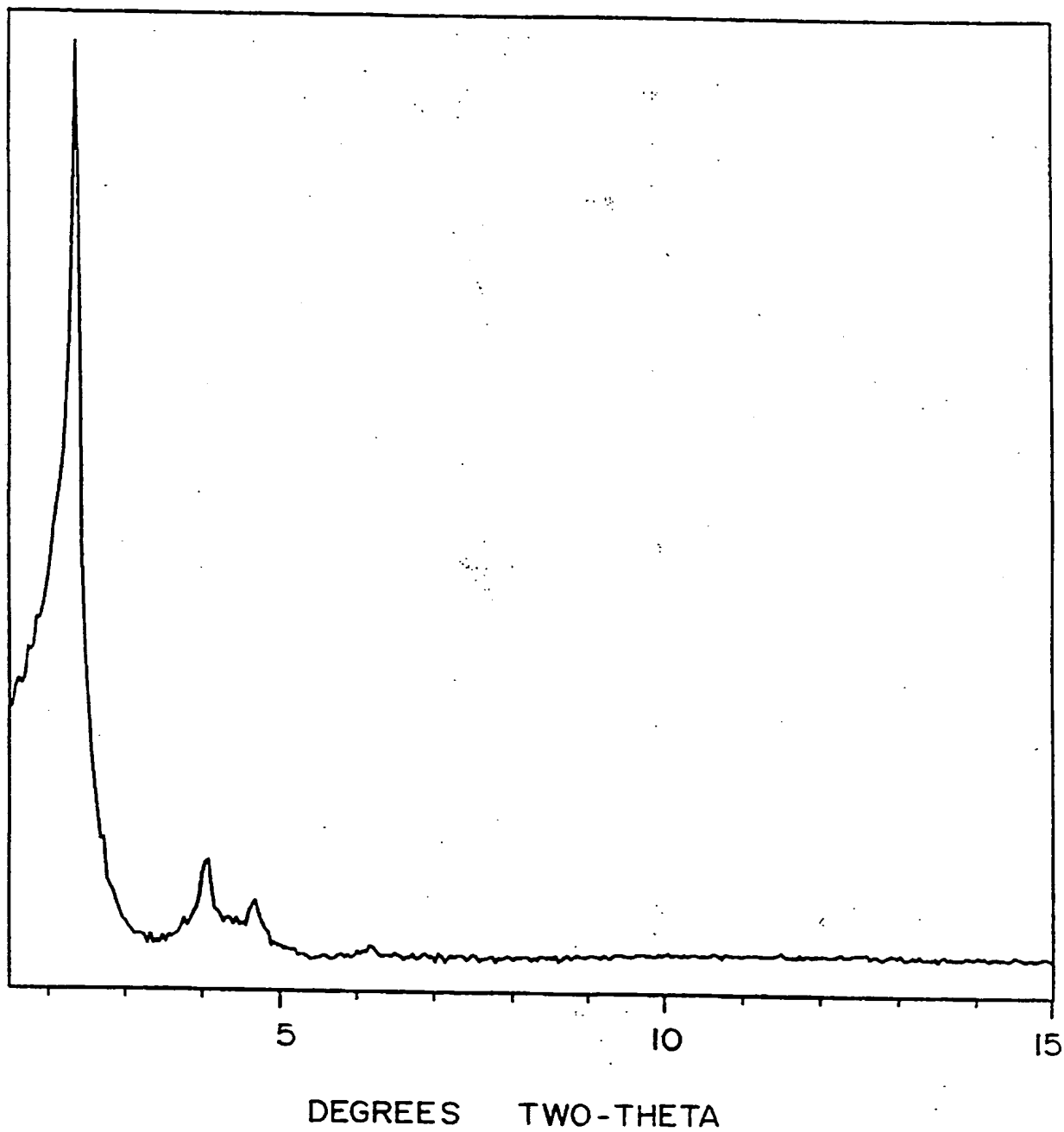


FIG. 25

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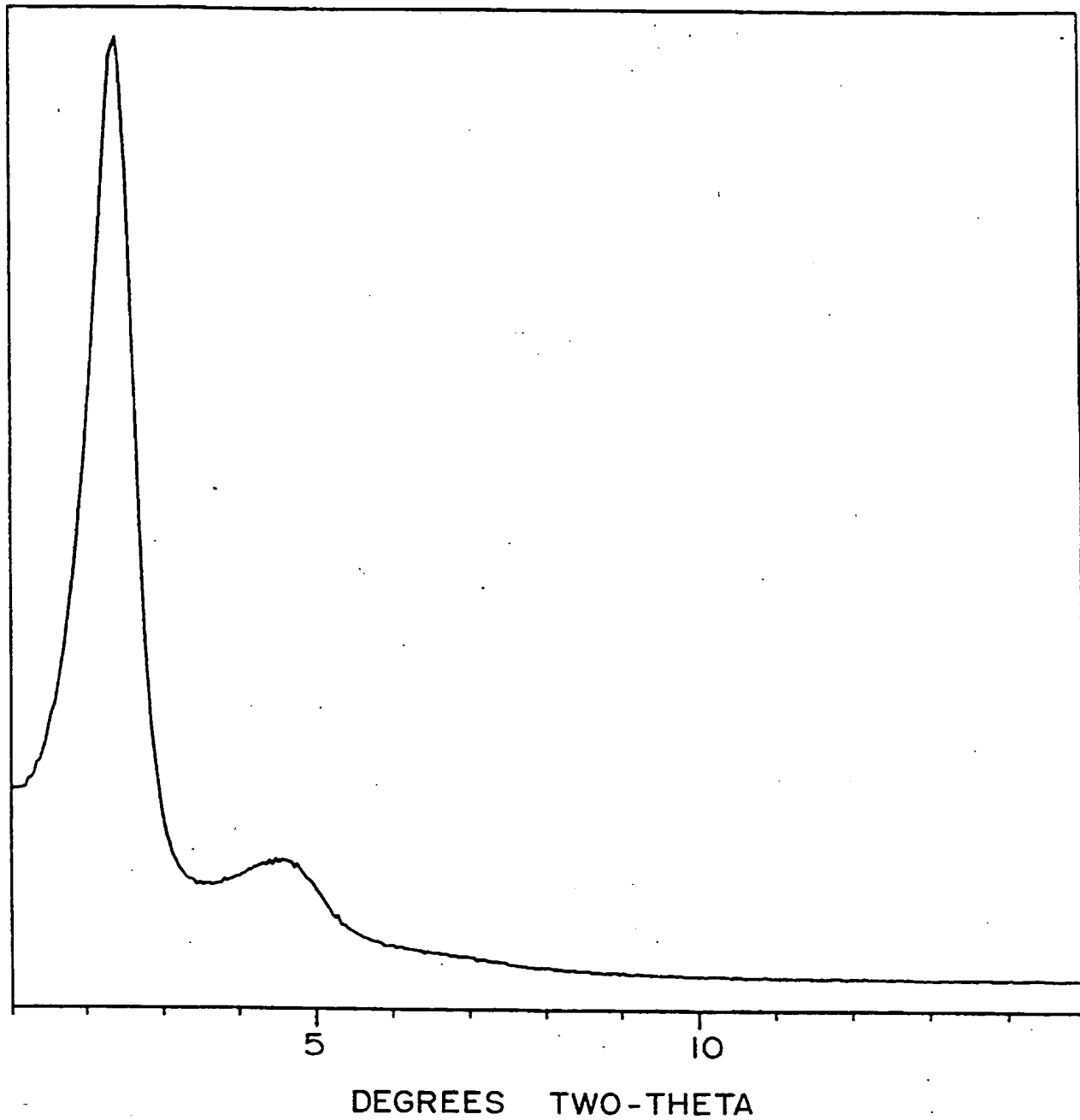


FIG. 26

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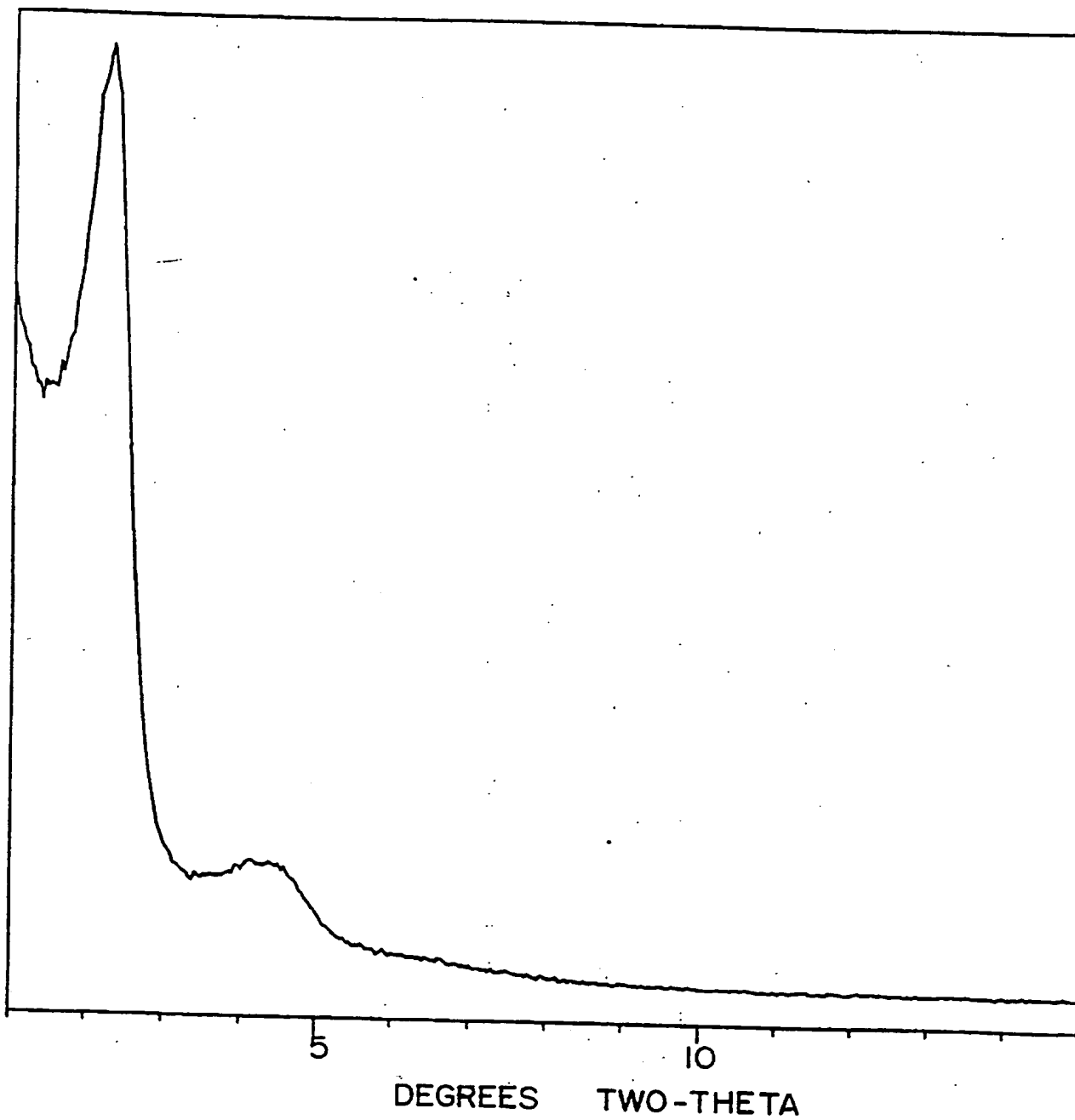


FIG. 27

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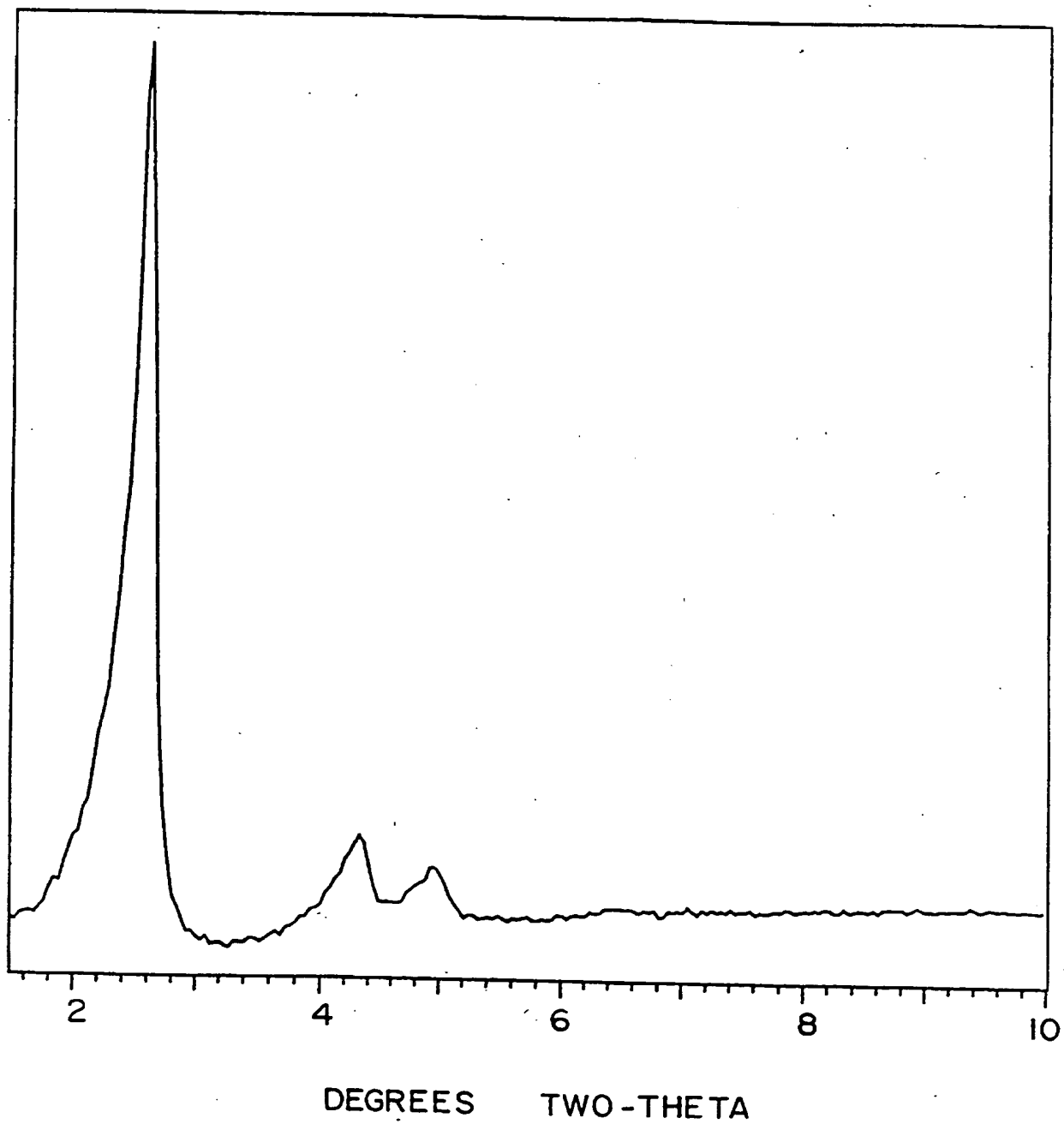


FIG. 28

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